RELIABLE

8000DT

AUTOMATIC CHAINSTITCH DRAPERY TACKER

INSTRUCTION MANUAL

IMPORTANT SAFETY INSTRUCTIONS

Putting sewing systems into operation is prohibited until it has been ascertained that the sewing systems in which these sewing machines will be built into, have conformed with the safety regulations in your country. Technical service for those sewing systems is also prohibited.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction Manual before you use the machine. In addition, keep this Instruction Manual so that you may read it at anytime when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
   - 7-1 For threading needle(s), looper, spreader etc. and replacing bobbin.
   - 7-2 For replacing part(s) of needle, presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, cloth guide etc.
   - 7-3 For repair work.
   - 7-4 When leaving the working place or when the working place is unattended.
   - 7-5 When using clutch motors without applying brake, it has to be waited until the motor stopped totally.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.

9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel. Only spare parts designated by JUKI can be used for repairs.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
13. Before making repair and maintenance works on the machine equipped with pneumatic parts such as an air cylinder, the air compressor has to be detached from the machine and the compressed air supply has to be cut off. Existing residual air pressure after disconnecting the air compressor from the machine has to be expelled. Exceptions to this are only adjustments and performance checks done by appropriately trained technicians or specially skilled personnel.
14. Periodically clean the machine throughout the period of use.

15. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
16. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to a grounded receptacle.

17. The machine is only allowed to be used for the purpose intended. Other used are not allowed.
18. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. assumes no responsibility for damage caused by remodeling or modification of the machine.

19. Warning hints are marked with the two shown symbols.

Danger of injury to operator or service staff

Items requiring special attention

FOR SAFE OPERATION

	1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.
	1. To avod personal injury, never operate the machine with any of the belt cover, finger guard, eye protection cover or safety devices removed. 2. To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the handwheel, V belt and the motor while the machine is operating. In addition, place nothing around them. 3. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine. 4. To avoid possible personal injuries, be careful not to allow your fingers to place in the machine when tilting/raising the machine head. 5. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head or removing the belt cover and the V belt. 6. To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed. 7、To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection/disconnection of the power plug.

為了安全地使用 -373 377 縫紉機的肴意事項

 警告	1. 為了防止發生觸電事故，請不要在打開電源的狀態下，打開電氣箱蓋及觸摸電氣箱內的零件。
 注意	1. 為了防止人身事故的發生，請不要在卸下皮帶防護罩、手指防護器等安全裝置的狀態下運轉縫紉機。 2. 為了防止被卷入機器的人身事故，縫紉機運轉中請不要將手指、頭髮、衣服靠近皮帶輪、V形皮帶、馬達，也不要把東西放到機器上面。 3. 為了防止人身事故的發生，打開電源時以及縫紉機運轉中，請不要把手指放到機針的附近。 4. 為了防止人身事故的發生，縫紉機運轉中請不要把手指放到挑線桿外罩內。 5. 為了防止突然的起動造成人身事故，放倒縫紉機時，或卸皮帶罩和V形皮帶時，請一定關掉電源。 6. 為了防止觸電事故，卸下電源地線的狀態，請不要運轉縫紉機。 7. 為了防止觸電和損壞電氣零件，拔電源的插頭時，請先關掉機器電源開關。

CONTENTS

-373

1. SPECIFICATIONS 1
2. INSTALLATION OF MACHINE HEAD 2
3. LUBRICATION 2
4. ATTACHING THE NEEDLE 3
5. ATTACHING THE NEEDLE BAR GUARD 3
6. ATTACHING THE BUTTON TRAY ASSEMBLY 4
7. THREADING THE MACHINE 4
8. THREAD TENSION ADJUSTMENT 5
9. ADJUSTMENT OF THE THREAD PULL-OFF LEVER 5
10. NEEDLE-TO-LOOPER RELATION 6
11. ADJUSTMENT OF THE NIPPER 7
12. POSITION OF THE NEEDLE GUIDE 7
13. HEIGHT OF THE BUTTON CLAMP 8
14. WORK PRESSING FORCE 8
15. ADJUSTMENT OF THE BUTTON CLAMP STOP LEVER 8
16. TIMING OF THREAD TENSION RELEASE 9
17. SETTING FOR 2- OR 4-HOLE BUTTONS 9
18. SETTING A NUMBER OF STITCHES 10
19. AUTOMATIC THREAD TRIMMER 11
20. SUBCLASS MODELS 12
21. ATTACHMENTS 13
22. MOTOR PULLEY AND BELT 18
23. TROUBLES AND CORRECTIVE MEASURES 19

-377

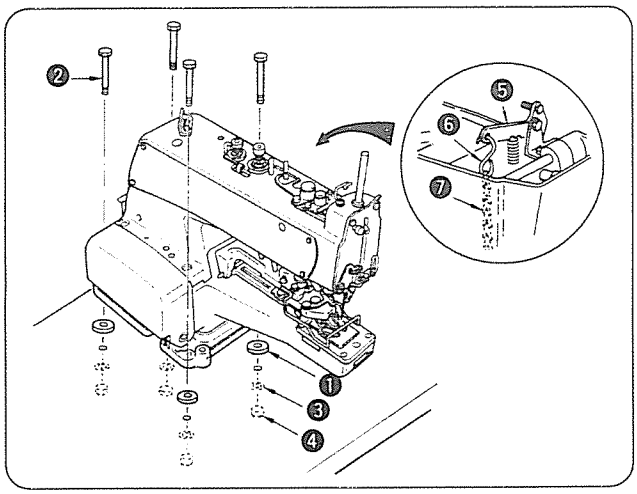
1. SPECIFICATIONS 1
2. ATTACHING THE NEEDLE BAR COVER 21
3. THREADING THE MACHINE HEAD 22
4. ADJUSTING THE TENSION LEVER 22
5. ADJUSTING THE NIPPER 23
6. ADJUSTING THE THREAD TENSION GUIDE ON THE FACE PLATE 24
7. ADJUSTING THE HEIGHT OF THE BUTTON CLAMP UNIT 24
8. ADJUSTING THE TIMING OF THREAD TENESION RELEASE 25
9. KNOT-TYING MECHANISMS 25
   (1) ADJUSTING THE KNOT-TYING ARM STOPPER 25
   (2) ADJUSTING THE KNOT-TYING NOTCH 26
   (3) ADJUSTING THE KNOT-TYING CONNECTING PLATE 26
10. AUTOMATIC THREAD TRIMMER 27
11. OTHER ADJUSTMENT 27
12. SUBCLASS MODELS 27
13. ATTACHMENTS 28
14. CAUSES OF TROUBLES AND CORRECTIVE MEASURES 29

1. SPECIFICATIONS / 規格

	-373	-377
Sewing speed	Max. 1,500 rpm (Normal 1,300 rpm)	Max. 1,500 rpm (Normal 1,300 rpm)
Number of stitches	8, 16 and 32 stitches (6, 12 and 24 by changing the cam)	8, 16, 32
Feed amount	Lateral feed 2.5 to 6.5 mm Longitudinal feed 0, 2.5 to 6.5 mm	
Button size	10 to 28 mm	
Needle used	TQx1 #16 (#14 to #18) TQx7 #16 (#14 to #20)	
Lubricating oil	New Defrix Oil No. 1	

	-373	-377
縫製度速	最高 1,500rpm（敍用 1,300rpm）	最高 1,500rpm（敍用 1,300rpm）
針數	8,16,32 針（更換凸輪後可為 6,12,24 針）	8,16,32 針
送布量	橫向送布 2.5 ～ 6.5mm 豎送布 0,2.5 ～ 6.5mm	
鈕釦尺寸	10 ～ 28mm	
使用機針	TQx1 #16(#14 ～ #18) TQx7 #16(#14 ～ #20)	
機油	No.1 新機油	

2. INSTALLATION OF MACHINE HEAD / 縫紉機的安裝



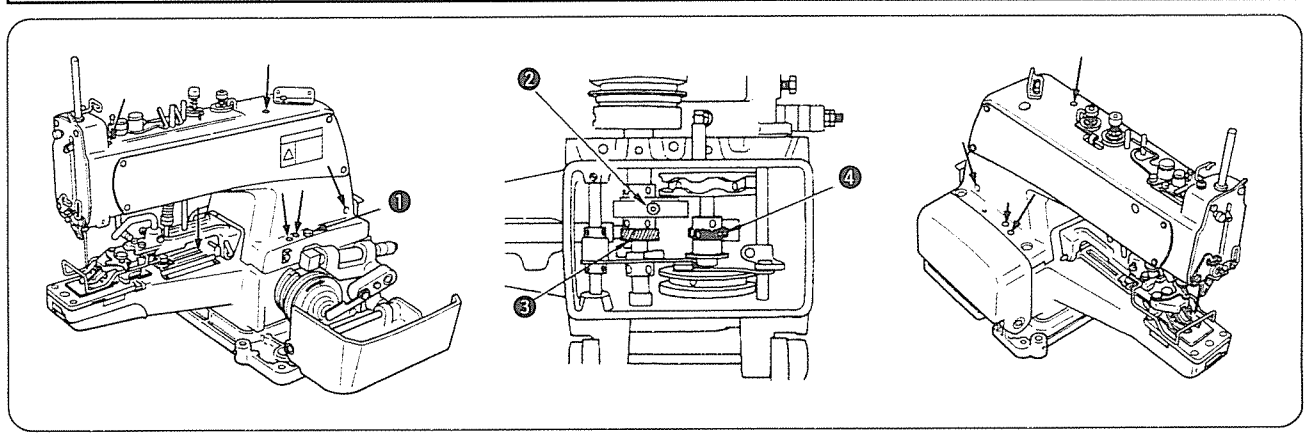
Put rubber cushion ❶ on the table, place the machine head on the rubber cushion and fix it to the table using screws ❷, plain washers ❸ and nuts ❹. Attach "S" chain hook ❻ and chain ❼ to stop motion trip lever ❺.

把防震膠墊❶放到機台上，然後把機頭放到上面，用固定螺絲❷、墊片❸、螺母❹固定好。
然後把 S 型掛鉤❻和鐵鏈❼安裝到起動環❺上。

3. LUBRICATION / 加油

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



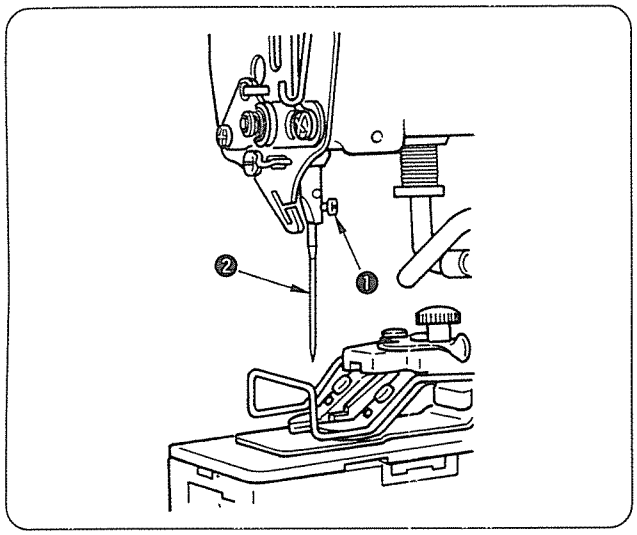
1. Apply New Defrix Oil to the components shown by the arrows. (Once or twice a week)
2. Loosen connecting screw ❶, tilt the head backward and apply some grease to driving worm gear ❹ and gear ❸.
3. Check, approximately once a week, that oil amount is sufficient to reach the top of the oil felt placed inside the bed mounting base. If the amount of oil is insufficient, add an adequate amount of oil. At this time, also apply oil to crank rod ❷.

1. 把 新機油加入到箭頭部。（每週 1 ～ 2 次）
2. 擰鬆安裝螺絲❶，放倒縫紉機，把潤滑脂加到螺旋齒輪❸和渦輪❹上。
3. 每週檢查 1 次機座安裝台內的加油毛氈上面是否吸滿油，不夠時請加油。同時請往曲軸部❷上也加油。

4. ATTACHING THE NEEDLE / 機針的安裝方法

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



★ Use a standard needle of TQx7 #16.

1. Loosen screw ❶.
2. Insert needle ❷ up into the needle hole in the needle bar until it comes in contact with the deepest end of the needle hole.
3. Tighten screw ❶ firmly.

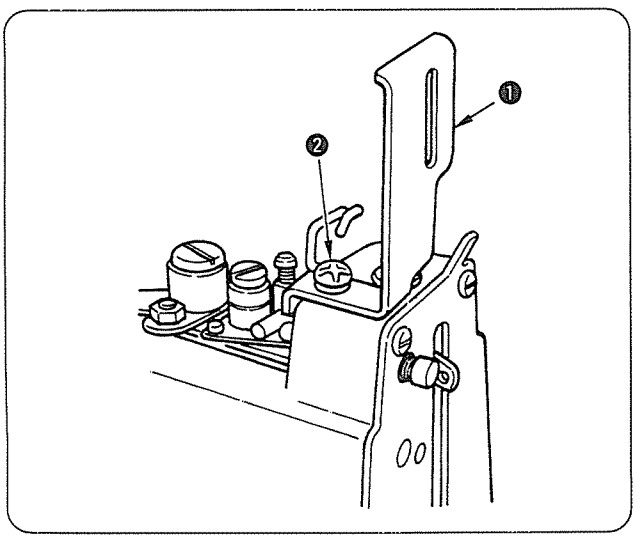
★標準機針為使用 TQx7 #16。

1. 擰鬆機針固定螺絲❶，手拿機針把機針❷長溝轉到面前。
2. 把機針❷插進針桿孔的紳處。
3. 擰緊機針固定螺絲❶。

5. ATTACHING THE NEEDLE BAR GUARD / 針桿罩的安裝方法

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



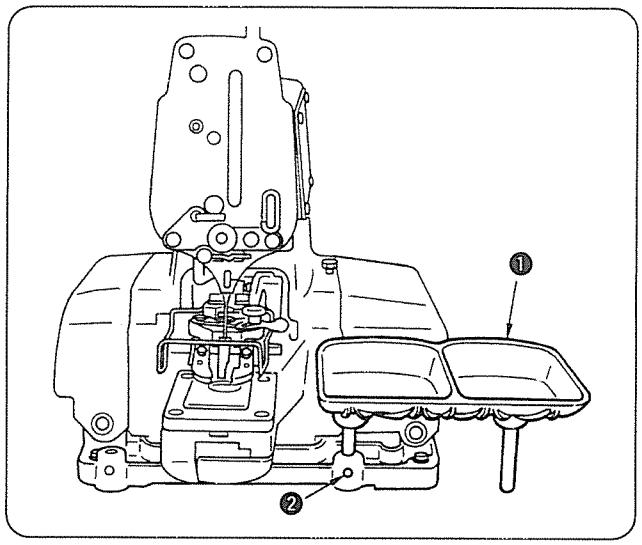
1. Loosen screw ❷ and remove the thread guide No. 2.
2. Place needle bar guard ❶ under the thread guide No. 2.
3. Fix the thread guide No. 2 and needle bar guard ❶ together using screw ❷.

Caution **If your machine has a wiper magnet, attach the needle bar guard onto the wiper magnet base.**

1. 擰鬆固定螺絲❷，並把它卸下。
2. 把針桿罩❶安裝到第二導線器的下面。
3. 用固定螺絲❷固定起來。

注意 **如果裝挑線電磁閥時，請把針桿罩安裝到挑線電磁閥安裝台座上。**

6. ATTACHING THE BUTTON TRAY ASSEMBLY / 鈕釦盤的安裝方法



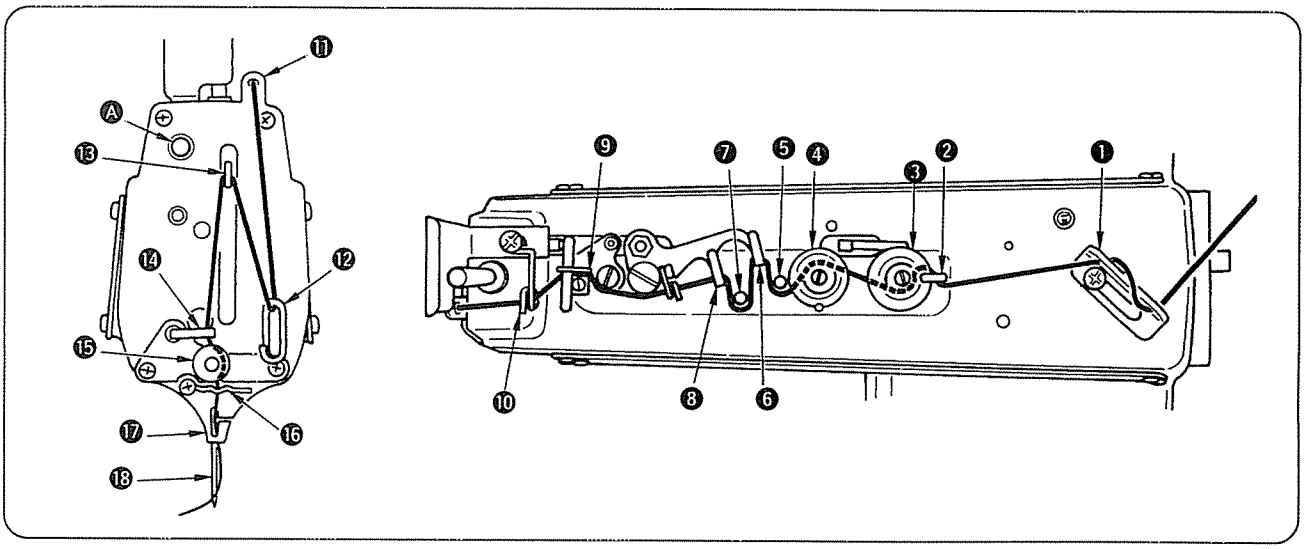
Insert the posts of button tray ❶ in hole on the right of the machine sub-base and tighten each setscrew ❷. You may use also the installation hole on the left if the operator wants.

把鈕釦盤❶插進機座前部的右側的孔上，並把固定螺絲❷擰緊固定。如果，右側抓鈕釦不方便的話，請改裝到左側。

7. THREADING THE MACHINE / 上線穿線方法

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

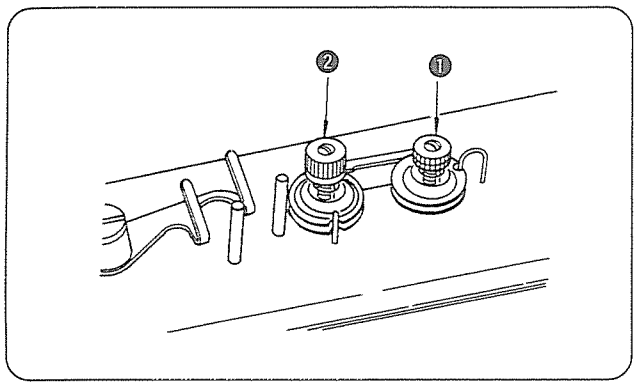
注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



Thread the machine in the order of ❶ to ⓲ as illustrated and pass the thread through the needle eye from the front for 60 to 70 mm as you depress nipper releasing knurled thumb nut Ⓐ.

如圖所示的順序進行穿線，從針孔的前側向後側按鬆線螺母Ⓐ，把線拉出約 60 ～ 70mm 左右。

8. THREAD TENSION ADJUSTMENT / 線張力



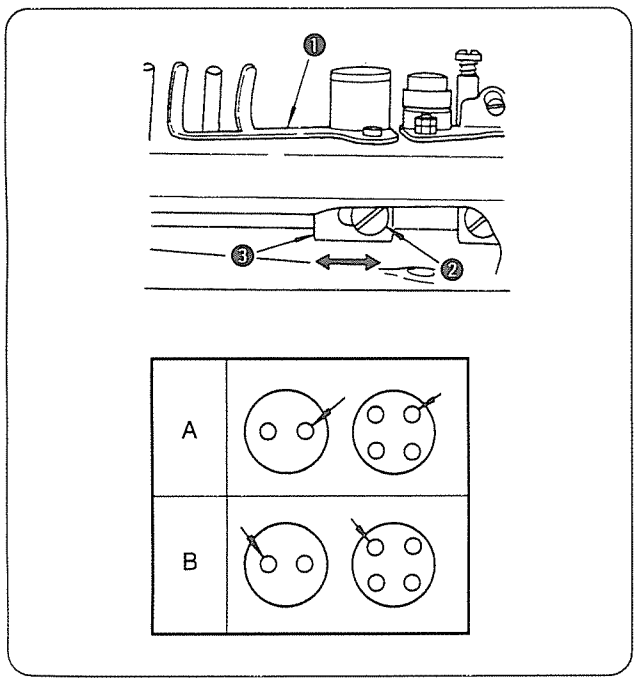
Tension post No. 1 ❶ is used to adjust the thread tension to sew on the button and a relatively low tension will be enough. Tension post No. 2 ❷ is used to adjust the thread tension applied to the root of the button sewing stitches.
This tension must be determined according to the type of thread, fabric and thickness of the button and must be higher than that of tension post No. 1 ❶. Turn the tension nuts clockwise to increase or counterclockwise to reduce the thread tension.

第一線張力螺母❶是調整釘釦強度用的，僅能調詳極小的張力。
第二線張力調整螺母❷是調整背面的緊線程度的，其張力比第一線張力螺母❶強，根據使用的機線、布料、釦釦厚度等情況進行調整。
向右轉動各線張力螺母之後，線張力變強，向左轉動則張力變弱。

9. ADJUSTMENT OF THE THREAD PULL-OFF LEVER / 線調詳桿的調整

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



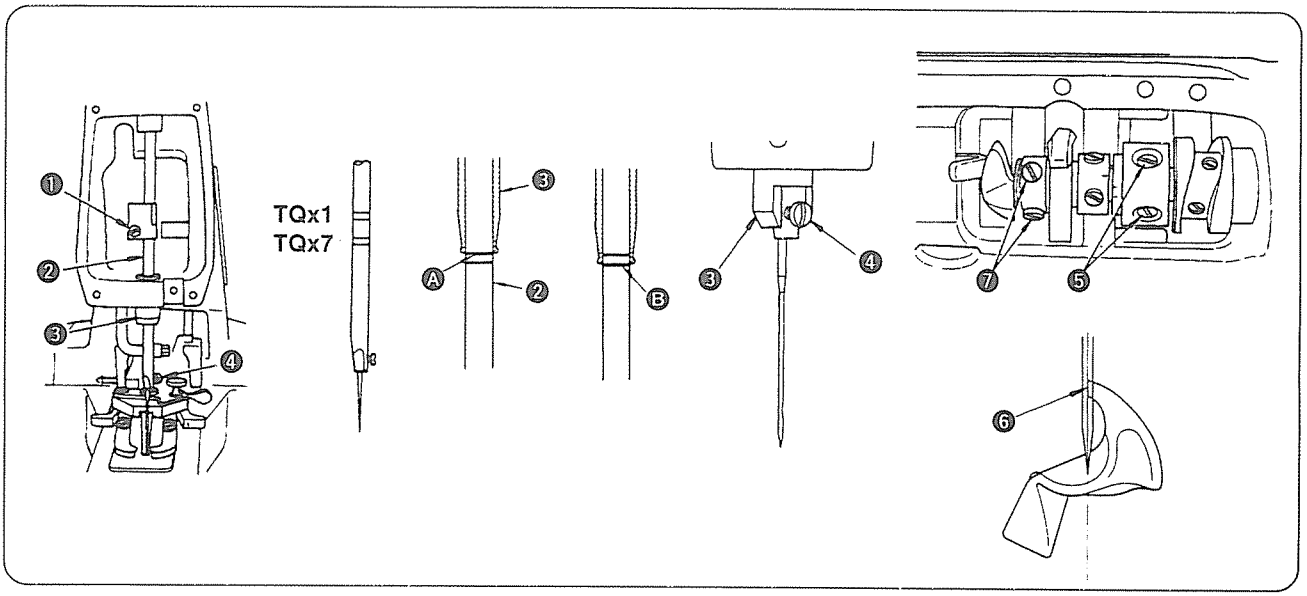
To adjust the thread pull-off lever ❶, insert a screwdriver through an opening in the machine arm side cover (left), loosen screw ❷ and adjust the position of nipper bar block (rear) ❸ to the left or the right. If the end of thread is drawn from arrow hole A in the button after sewing, change the pòsition of nipper bar block (rear) ❸ to the left. Move the lever to the right when the thread end comes out from arrow hole B.

調詳線調詳桿❶時，請把螺絲刀插進左側面板上的孔中，擰鬆固定螺絲❷，然後左右移動調詳桿的活動滑塊❸進行調整。縫製結束，如果線頭從 A 部箭頭的孔中露出時，請把線調詳桿活動滑塊❸向左移動，如果線頭從 B 部箭頭的孔中露出時，請把滑壞向右移動，不讓線頭露出來。

10. NEEDLE-TO-LOOPER RELATION / 機針和彎針的關係

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



★ Adjust the needle-to-looper relation as follows :

1. Depress the pedal fully forward, turn the needle driving pulley in the normal sewing direction to bring down the needle bar to the lowest point of its stroke and loosen screw ❶.

(Adjusting the needle bar height)

2. Adjust the height of the needle bar using top two lines engraved on the needle bar for the TQx1 needle and using the bottom two lines for the TQx7 needle. Align the upper line Ⓐ with the bottom end face of needle bar bushing (lower) ❸ and tighten screw ❶ in the way that needle clamp screw ❹ rests in the slot of the needle bar bushing (lower) ❸.

(Looper position)

3. Loosen screws ❺ and turn by hand the needle driving pulley until lower line Ⓑ of two lines aligns with the bottom end face of needle bar bushing (lower) ❸.
4. By keeping the machine in this state, align looper blade ❻ with the center of the needle and tighten screws ❺.
5. Loosen screws ❼ and provide a 0.01 to 0.1 mm clearance between the looper and the needle. Tighten screws ❼.

★機針和彎針按如下方法進行調整。

1. 把踏板踩到底，沿轉動方向驅動皮帶輪，讓針桿落到最下點，然後擰鬆固定螺絲❶。

(決定針桿高度。)

2. TQ×1機針時，使用上方的2條刻線，TQ×7機針時，使用下方的2條刻線，把其中的上刻線Ⓐ對準針桿下端塊❸的下端，然後擰緊固定螺絲❶。這時應讓機針固定螺絲❹進入到避免與針桿下端塊❸相碰的溝槽裡。

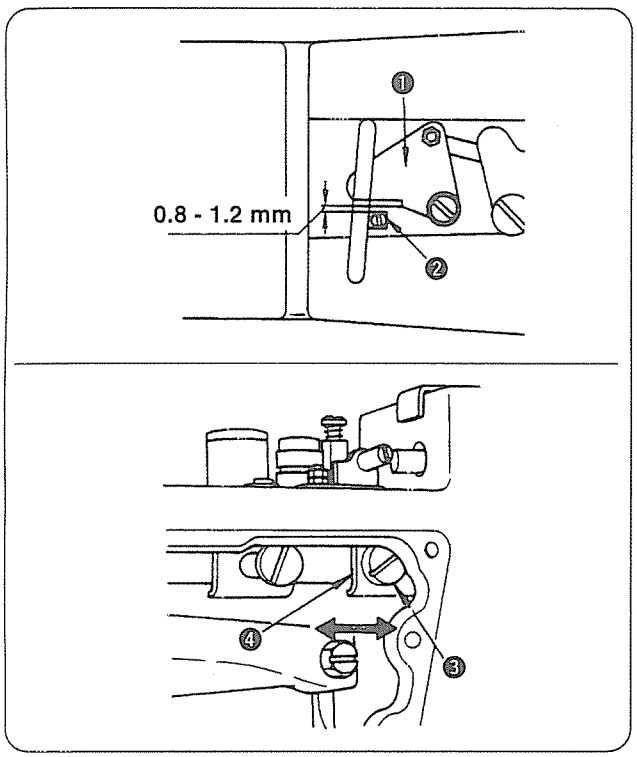
(決定彎針的位置。)

3. 擰鬆固定螺絲❺，轉動皮帶驅動輪，把針桿❷的2條一組的刻線中的下刻線Ⓑ對準針桿下端塊❸的下端。
4. 在此狀態，把彎針的針尖❻對準機針的中心，然後擰緊固定螺絲❺。
5. 擰鬆固定螺絲❼，把彎針間隙調整為0.01～0.1mm，再擰緊螺絲❼。

11. ADJUSTMENT OF THE NIPPER / 拔針器的調整

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



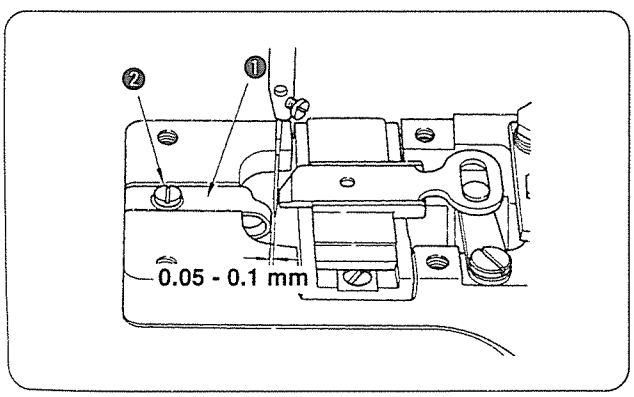
Provide a 0.8 to 1.2 mm clearance between nipper ❶ and nipper block ❷ to prevent the nipper from nipping the thread while stitching. Loosen screw ❸ and move nipper bar block ❹ to the left or the right.

運轉時，把拔針器的方塊❷和拔針器❶的間隙調整為 0.8 ～ 1.2mm ，不讓拔針器❶壓住機線。
調詳方法是，擰鬆固定螺絲❸，左右移動拔針器活動滑塊❹。

12. POSITION OF THE NEEDLE GUIDE / 針導向器的位置

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



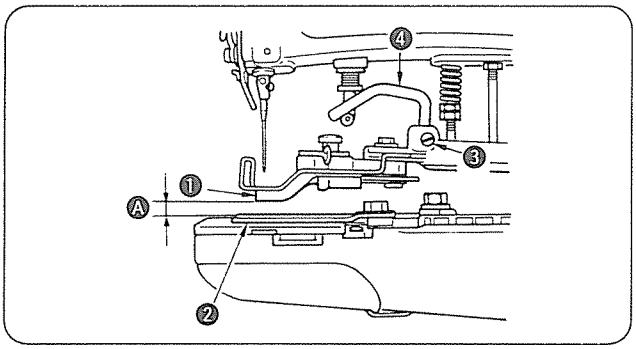
Loosen screw ❷ and provide a 0.05 to 0.1 mm clearance between the needle guide ❶ and the needle by moving the needle guide ❶ to the left or the right when the needle is in the lowest position.

在針桿最下點，擰鬆螺絲❷，左右移動針導向器❶，把機針和針導向器❶的間隙調整為 0.05 ～ 0.1mm 。

13. HEIGHT OF THE BUTTON CLAMP / 抓釦裝置的高度

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



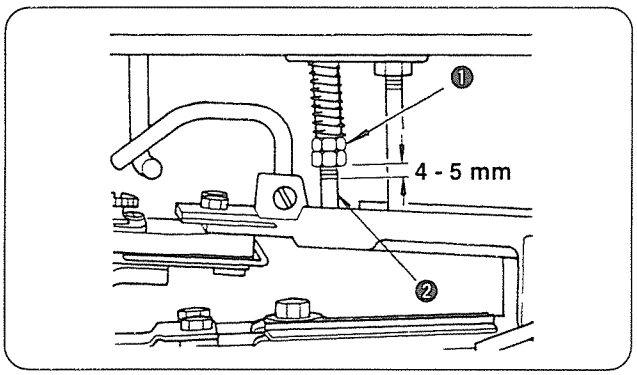
The standard clearance Ⓐ between the bottom face of button clamp jaw lever ❶ and the top face of feed plate ❷ is 9 mm for -373 . Loosen screw ❸ and adjust the height of button clamp lifting hook ❹.

在斷開位置，鈕釦抓腳❶的底面和布壓腳下板❷上面的間隔Ⓐ， -373 的標準為 9mm 。

14. WORK PRESSING FORCE / 布壓腳壓力的調詳

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



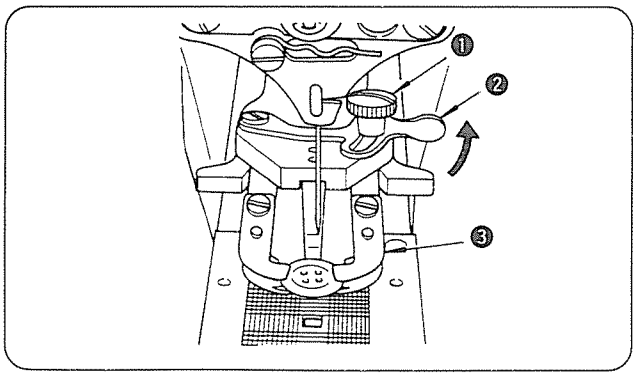
The standard work pressing force is obtained by providing a 4 to 5 mm clearance between the bottom face of nut ❶ and the bottom end of the screw of pressure adjusting bar ❷.

布壓腳的壓力，以在轉動螺母❶2個螺母的下端和壓腳壓力調詳桿❷的螺絲部間隙為 4 ～ 5mm 時為標準。

15. ADJUSTMENT OF THE BUTTON CLAMP STOP LEVER / 抓腳打開撥桿的調整

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

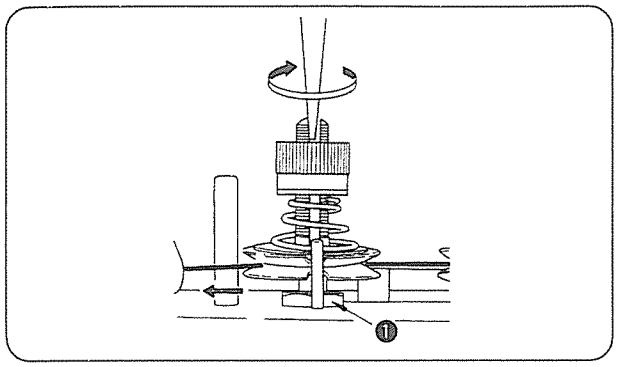
注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



Set the machine for stop-motion state, loosen clamp screw ❶, place a button correctly in the sewing position and adjust button clamp stop lever ❷ to permit the button properly to rest on button clamp jaw levers ❸. Tighten clamp screw ❶ after determining the distance between the left and right jaw levers ❸.

在斷開狀態，擰鬆固定螺絲❶，用抓腳打開撥桿❷開關打開抓腳❸，把鈕釦設定到正確的位置。讓鈕釦容易放進取出，然後擰緊螺絲❶。

16. TIMING OF THREAD TENSION RELEASE / 鬆線同步時間的調整



Turn the needle driving pulley as you draw the thread in the direction of the arrow as illustrated and you will find a point at which the tension disc on the tension post No. 2 release the thread. At this moment, the standard distance from the top end of the needle bar to the top end of the needle bar bushing (upper) is 53 to 56 mm for -373 . Perform the following adjustments especially when the undermentioned troubles occur frequently.

Loosen nut ❶, insert the blade of a screwdriver to the top slot of the tension post No. 2 and turn it in the direction of the arrow to lower the needle bar, (to reduce the said distance), and vice versa.

Your adjustment is required when following troubles are frequently ;

Phenomenon	Height of needle bar
1. When the stitch made on the wrong side of the workpiece is too loose ;	Make the needle bar slightly higher.
2. When the thread is broken at the time of stop-motion ;	Make the needle bar slightly higher.
3. When the thread is broken frequently ;	Make the needle bar slightly lower.

沿箭頭方向拉機線，轉動驅動皮帶輪，有一個第二線張力盤浮起，機線迅速拔出的點。此時，從針桿上端塊上面到針桿上端的高度為 -373 使用 53 ～ 56mm 時為標準。

特別是頻繁發生下列現象時，進行如下調詳。

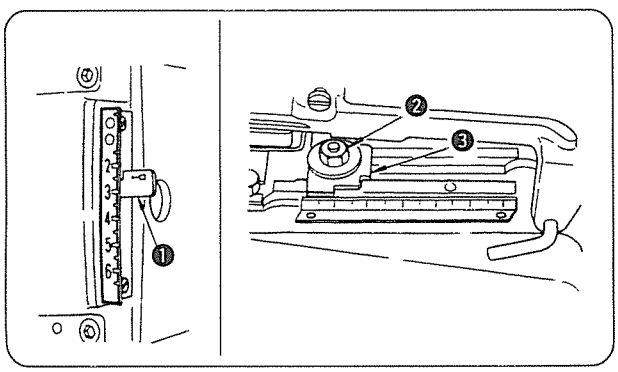
擰鬆螺母❶，把螺絲刀插入第二線張力桿，沿箭頭方向轉動的話，針桿高度變低，向相反方向轉動，則變高。

現象	針桿高度
1. 布料裡側的緊線不好時。	稍稍高一點。
2. 斷開時，機線中途斷線時。	稍稍高一點。
3. 經紋斷線時。	稍稍低一點。

17. SETTING FOR 2- OR 4-HOLE BUTTONS / 2 眼和 4 眼釦的調整

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



Measure the distance between two holes in a button and set equally crosswise and lengthwise feed regulators for 4-hole buttons.

★ Lengthwise feed

Push down lengthwise feed adjusting lever ❶ and set it to "0" for 2-hole buttons or a corresponding amount for 4-hole buttons.

★ Crosswise feed

Loosen nut ❷ and set pointer ❸ to a corresponding amount indicated by the crosswise feed regulation plate. Tighten firmly nut ❷.

Before operating the machine, ensure that the needle enters the center of each hole in the button.

首先量一下鈕釦孔間隔有幾 mm ，4 眼鈕釦的豎送量和橫送量值應設為相同。

★豎送量

向下壓豎送調詳桿❶，2 眼鈕釦時設到 0 的位置，4 眼鈕釦時根據測定值進行設定。

★橫送量

擰鬆螺母❷，把指針❸對準相應的刻度，然後擰緊螺母❷。

請確認機針準確地落入鈕釦各孔的中心後再運轉縫紉機。

18. SETTING A NUMBER OF STITCHES / 針數

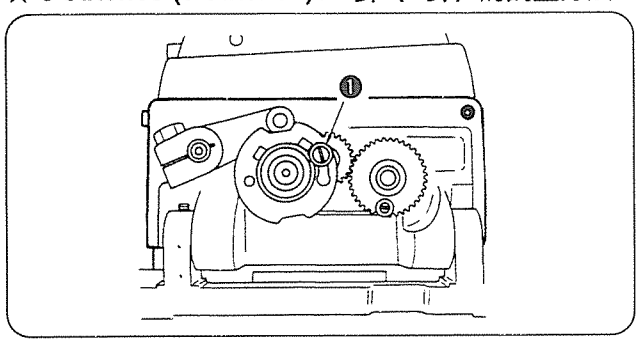
WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。

To change the number of stitches, open the left-hand side cover and change the number of stitches using stitch number adjusting knob ❶ and stitch number adjusting lever ❹ (optional). The illustration gives the machine with the auxiliary stop device removed. The number of stitches can be changed with ease with the auxiliary stop device attached.

變更針數時，打開左側防護罩，用針數調詳旋鈕❶和針數調詳撥桿❹（選購品）進行調整。另外，下圖是卸下預備停止裝置後的圖示，不卸下來也能變換針數。

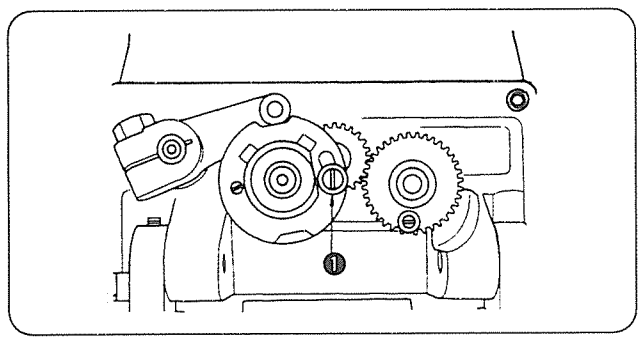
★ 8 stitches (6 stitches) / 8針（6針）的調整方法



Pull stitch number adjusting cam knob ❶ and set it as shown in the illustration.

設定為8針時，請把針數調詳旋鈕❶向前拉出然後轉到圖示的位置。

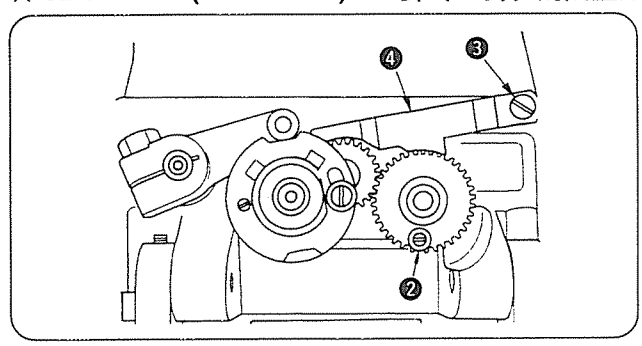
★ 16 stitches (12 stitches) / 16針（12針）的調整方法



When stitch number adjusting cam knob ❶ being set for "8 stitches" has arrived at the right end as illustrated, set knob ❶ in the illustrated position.

在設定為8針的狀態下，把針數調詳旋鈕❶再繼續向右轉，把針數調詳旋鈕❶設定到圖示的位置。

★ 32 stitches (24 stitches) / 32針（24針）的調整方法



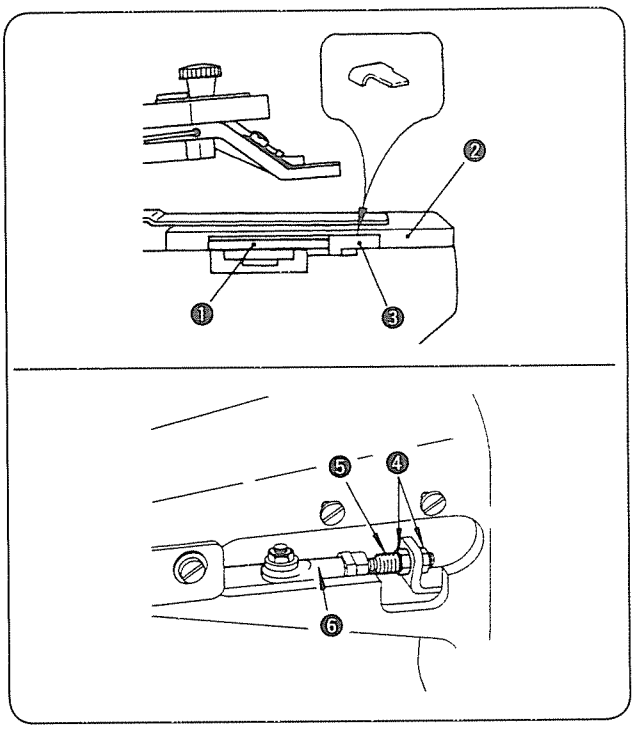
When the number of stitches is set to 16, move stitch number adjusting gear roller ❷ to the lower position. Now, attach stitch number adjusting lever ❹ (optional) in position using screw ❸ (optional).

設定為16針的狀態下，針數調詳齒輪螺絲❷轉到下側時，用螺絲❸（選購品）安裝上針數調詳撥盤撥桿❹（選購品）。

19. AUTOMATIC THREAD TRIMMER / 切線裝置

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。

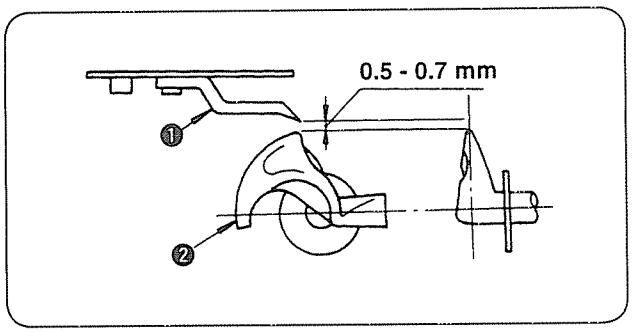


★ Position of the moving knife

When the machine stops in the state of "stop-motion" and its button clamp assembly rests in the highest position, there must be a standard clearance of 12.5 mm between thread trimming connecting link (front) ❶ and the end face of the slit in throat plate ❷. This clearance is determined by gauge ❸ which is stored in the accessory box ; tilt the head backwards, remove the bed oil shield, loosen two nuts ❹ and adjust the clearance by moving connecting screw ❺ in the axial direction. When you tighten two nuts ❹, ensure that joint ❻ stays in the horizontal position.

★移動刀位置的調整

分離後壓腳上昇到最高處時，切線連接板（前）❶和針板❷槽溝端面的間隔標準為 12.5mm 。
調詳 12.5mm時，請使用附屬品的定位尺❸，放倒縫紉機，卸下防油板，擰鬆螺母❹（2個），前後移動連結螺絲❺，進行調整。另外，擰緊螺母❹時，請看意切線連結接頭❻應基本保持水平。

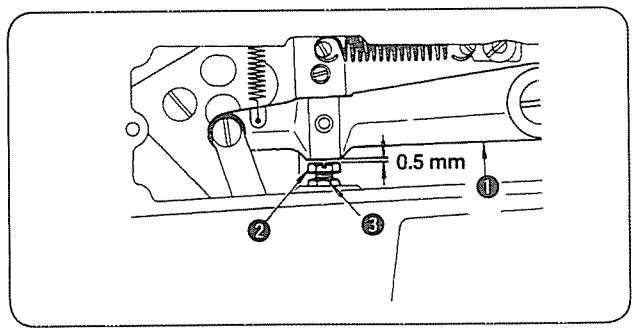


★ Height of the moving knife thread separation nail

There must be a 0.5 to 0.7 mm clearance between looper blade point ❷ and thread separation nail ❶. If nail ❶ does not provide the necessary clearance, bend the nail slightly and adjust the clearance.

★移動刀分線爪的高度調整

分線爪❶和彎針❷的間隙為0.5～0.7mm，如果分線爪高度不正確時，請弄彎分線爪❶。

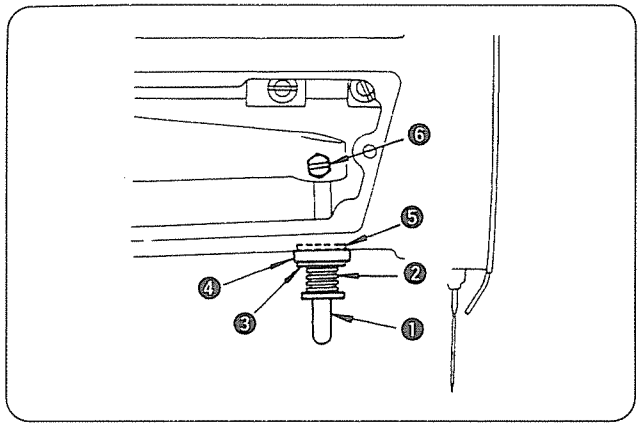


★ Clearance between the button clamp lifting lever and the adjusting screw

Provide a 0.5 mm clearance between button clamp lifting lever ❶ and adjusting screw ❷ and then tighten nut ❸.

★提昇撥桿和調詳螺絲的間隙

把提昇撥桿❶端面和調詳螺絲❷的間隙調整為 0.5mm，然後擰緊調詳螺絲螺母❸。



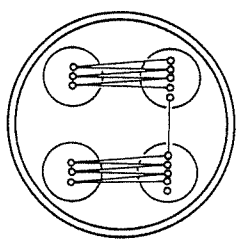
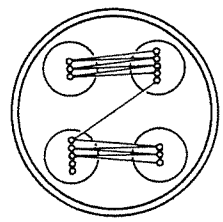
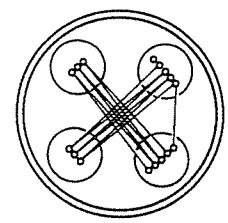
★ How to set the L-shaped lifting rod

Put moving knife push-back spring ❷, stop-motion rubber cushion washer ❸, stop-motion rubber cushion ❹ and stop-motion rubber cushion washer ❺, in this order, to L-shaped lifting rod ❶. After making sure that the stop-motion mechanism has engaged completely, fix the L-shaped lifting rod by tightening screw ❻ in the way that the end face of the stop-motion rubber cushion washer come into close contact with the jaw of the machine arm.

★ L型提昇桿的安裝方法

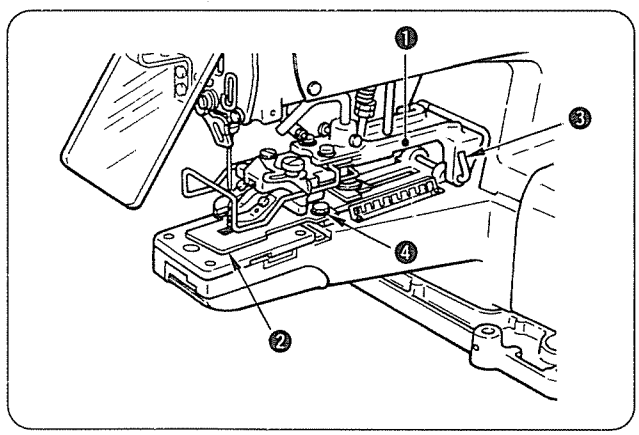
按移動刀反彈彈簧❷、分離墊片❸、分離墊❹、分離墊片❺的順序安裝到L型提昇桿上。確認完全分離之後讓機梁的凸部和分離墊片端面緊密結合，不要有任何鬆動，用螺絲❻擰緊固定。

20. SUBCLASS MODELS / 派生機種

MB-373NS	MB-373NS-10	MB-373NS-11
8, 16, 32 stitches 8 、 16 、 32 針	8, 16, 32 stitches 8 、 16 、 32 針	8, 16, 32 stitches 8 、 16 、 32 針
		

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

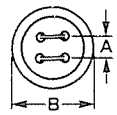
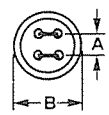
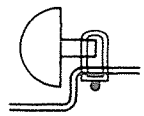
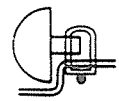
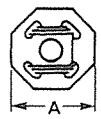
注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。

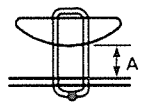
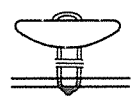
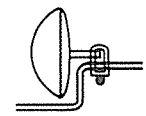
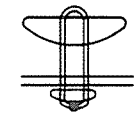
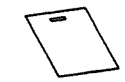


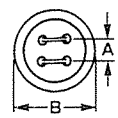
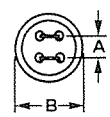
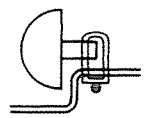
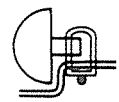
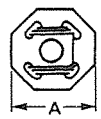
In order to install the attachment on the machine, you may have to remove the button clamp mechanism ❶ or feed plate ❷. Dislocate a snap ring from button clamp installing stud ❸, and you will be able to remove button clamp mechanism assembly ❶. Loosen setscrews ❹, and you can remove feed plate ❷.

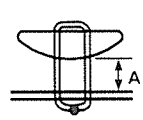
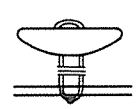
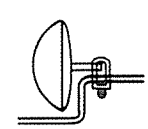
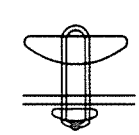
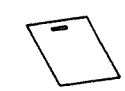
安裝各個附件時，有時必須卸下抓釦裝置❶、布壓腳下板❷，這時請卸下抓釦裝置安裝軸❸上的螺母，卸下布壓腳下板❷上的固定螺絲❹，即可以把它們卸下來。

21. ATTACHMENTS / 附件

Use	Flat buttons		Shank buttons		Snaps
	Large-size	Medium-size	General	Lewis type	
-373	Z031	Z032	Z033	Z040	Z037
Schematic drawing					
Remarks	Button size : A : 3 to 6.5 mm B : ø20 to ø28 mm	Button size : A : 3 to 5 mm B : ø12 to ø20 mm	Button diameter : Less than 16 mm Shank size : Thickness : 6 to 5 mm Width : 3 to 2.5 mm	Button size : Same as Z003 (Z033), but possible to sew buttons having some variations of shank in shape.	Snap size : A : 8 mm

Use	Wrapped-around buttons		Metal buttons	Stay button	Labels
	First process	Second process	General		
-373	Z004	Z035	Z038	Z039	Z044
Schematic drawing					
Remarks	Thread shank height : A : 5.5 mm			Common to Z004	Stitch width : 3 to 6.5 mm

用途	平釦用		柄釦用		子母釦用
	大鈕釦	中鈕釦	一般	LEWIS 型	
-373	Z031	Z032	Z033	Z040	Z037
示意圖					
備考	鈕釦尺寸 A : 3～6.5 mm B : Φ20～Φ28 mm	鈕釦尺寸 A : 3～5 mm B : Φ12～Φ20 mm	鈕釦直徑：16mm 柄尺寸 厚：6.5mm 寬：3，2.5mm	鈕釦尺寸與Z003 (Z033)相同 可以對應柄形狀的變化進行一些調整	尺寸: A : 8 mm

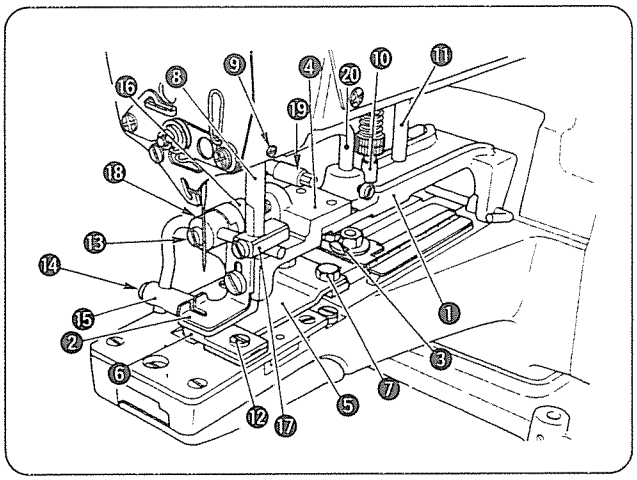
用途	鈕釦繞線用		金屬鈕釦用	力釦用	釘標牌
	第1工序	第2工序	一般		
-373	Z004	Z035	Z038	Z039	Z044
示意圖					
備考	釘釦高度: A : 5.5 mm			與Z004共通	折邊寬度: 3 to 6.5 mm

☆ Attachments for shank buttons (Pearl buttons) (Z033, Z040)

☆柄釦（真珠釦）釘釦附件（Z033,Z040）

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



(INSTALLATION)

Remove both the button clamp mechanism assembly and the feed plate from the machine and install attachment ❶ in place. Loosen screws ❸ and adjust button clamp bracket ❹ to permit the needle to come down in the middle of the needle slot in shank button adaptor ❷. Attach button clamp feed plate ❺ using screws ❼ in the way that it permits the needle to come down in the middle of the needle slot in feed plate ❻. Insert the top end of button clamp stud ❽ into an opening in the jaw of the machine arm and fasten it by screw ❾.

(When attaching Z040, you must change also button clamp pressure adjusting bar ❿ and button clamp stopper pin ⓫ at the same time.)

(ADJUSTMENT AND OPERATION)

1. Loosen screw ⓬, let feed plate ❻ recede 0.5 to 1.0 mm from the left end of button clamp jaw lever ❷ and retighten screw ⓬.
2. Set a button in place, loosen screws ⓭ and ⓮ and align shank button holding clamp ⓯ with the center of the button.
3. Shank button holding clamp ⓯ must give proper pressure to the button so that the button stays steadily in position while being sewn. Loosen a setscrew in thrust collar ⓰ and rotate the thrust collar until shank button holding clamp ⓯ provides proper pressure.
4. You may fix button clamp block ⓱ in a convenient position for operation.

Caution

1. **When you fix the thrust collar, ensure that button clamp rotating shaft ⓲ does not play axially in its bracket.**
2. **Adjust lifting hook ⓴ and stopper pin ⓫ so that L-shaped lifting rod roller ⓳ does not come in contact with button clamp bracket ❹.**

(安裝方法)

卸下抓釦裝置和布壓腳下板，安裝上珍珠釦用抓釦裝置❶，擰鬆固定螺絲❸，前後移動抓腳安裝台❹，讓機針正好落在抓腳❷的落針溝中間。同時，讓珍珠釦用布壓腳下板台❺正好落在落針溝中間，然後用固定螺絲❼固定起來。

把鈕釦壓開桿❽插進機架凸部的孔裡，再用固定螺絲❼固定起來。

（使用 Z040 時，還要更換壓腳壓力調詳桿❿和抓釦裝置止動銷⓫。）

(使用方法)

1. 擰鬆固定螺絲⓬，把布壓腳下板❻拉到離抓腳❷的左端面 0.5 ～ 1.0mm 的地方，然後擰緊固定螺絲⓬。
2. 裝上拗釦，擰鬆固定螺絲⓭和⓮，調詳鈕釦壓腳使其稍稍壓住鈕釦的中心。
3. 擰鬆推力環固定螺絲轉動推力環，調詳鈕釦壓腳壓力不讓鈕釦移動。

注意

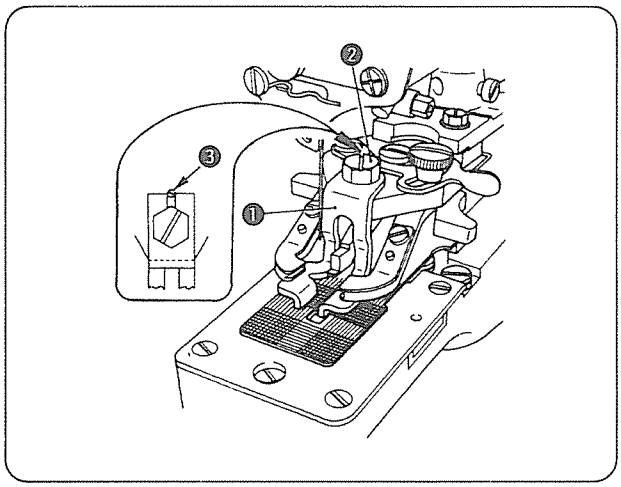
1. **轉動推力環後，不要讓轉動軸⓲在軸方向產生鬆動。**
2. **抓釦裝置上昇時，請調整抓釦裝置的提昇鉤和抓釦裝置的止動銷⓫，讓L型提昇桿凸塊⓳和抓腳安裝台❹不相碰。**

★ Attachment for the first process of wrapped-around buttons (Z004)

★繞線釦釦第 1 工序（釦釦工序）用附件（Z004）

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



(INSTALLATION)
Attach wrapped-around button foot ❶ to the ordinary button clamp jaw levers using screw ❷ and guide pin screw ❸. Align foot ❶ with the jaw levers so that they permit a button to rest in the middle.

(ADJUSTMENT AND OPERATION)
Adjustment and operation are almost same as those for the flat buttons, but you must adjust the thread pull-off lever to provide more amount of thread in order to make the thread loose below the button for thread shank formation. (See 9. Adjustment of the thread pull-off lever.)

(安裝方法)
用安裝螺絲❷和導銷螺絲❸把繞線用爪❶固定到普通的釦釦抓爪部。
此時，把釦釦抓爪❶安裝到釦釦中心左右均等的位置。

(使用方法)
與釘普通的平釦一樣，但是從釦釦到布之間的距離變長了，所以需要調節線調節撥桿把拉線量弄長。（參照「9. 線調節撥桿的調節」項）

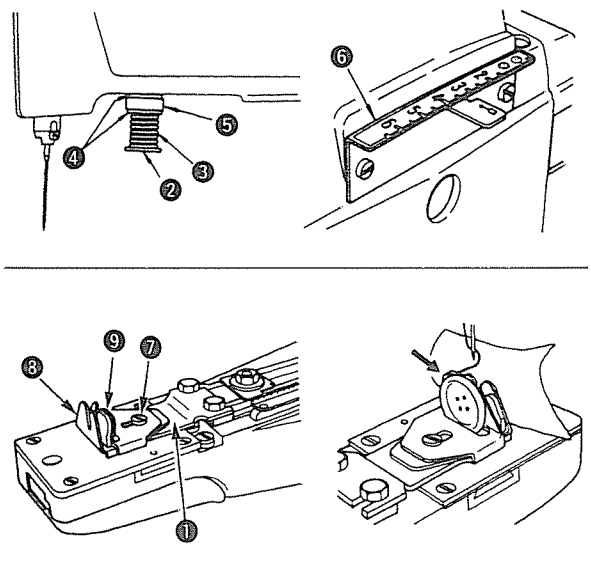
★ Attachment for the second process of wrapped-around buttons (Z035)

★繞線釦釦第 2 工序（繞線工序）用附件（Z035）

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。

(Z035)



(INSTALLATION)
Remove the button clamp mechanism assembly, button clamp pressure adjusting bar and feed plate from the machine and install attachment for the second process of wrapped-around buttons ❶. When you install a Z035 attachment, you must remove also the L-shaped lifting rod. Insert moving knife push-back spring ❸, washer ❹, cushion ❺ and washer ❹ in spring guide shaft ❷ in this order. Make certain that the stop-motion mechanism has completely engaged, and install the attachment assembly in place in the way that cushion ❺ comes in close contact with the surface of the machine arm without play. Then, replace lengthwise feed graduated plate ❻.

(ADJUSTMENT AND OPERATION)
1. Loosen screw ❼ and adjust the thread shank length by moving guide (large) ❽ and guide (small) ❾ in line with the point of needle entry.
2. Set a button (tilt it slightly for easy insertion) and pass the thread as the arrow shows.
3. Set the lengthwise feed to "0".
   When you sew 16 stitches with Z035, set it to "1.5 mm" instead of "0".

(安裝方法)

卸下抓釦裝置、壓腳壓力調詳桿和布壓腳底板，安裝上繞線第 2 工序用附件。

但是，Z035 需要卸掉 L 型拉桿，按照移動刀反彈彈簧❷、分離墊圈、分離墊片❺、分離墊圈❹的順序安裝，確認了完全分離之後，把機架和分離緩衝器❺的端面緊緊地安裝起來不讓它有鬆動。

同時還更換縱送布刻度板❻。

(使用方法)

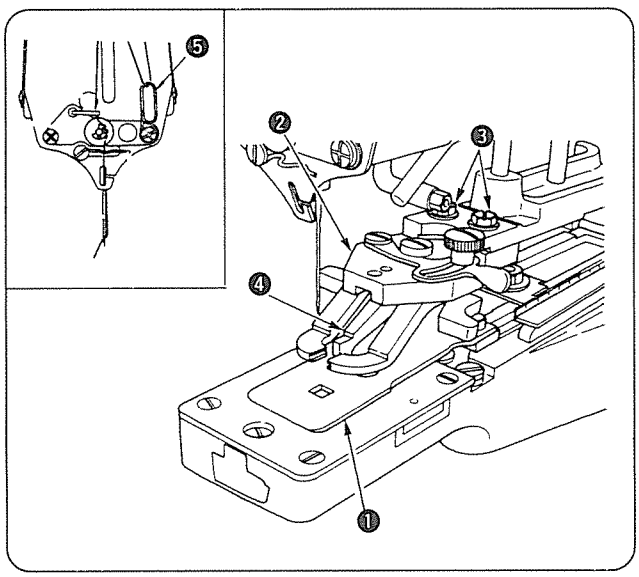
1. 擰鬆安裝螺絲❼，繞線用金屬部件（大）❽和繞線用金屬部件（小）❾移動到落針位置的中心，調詳繞線長度。
2. 把鈕釦放進，把線從箭頭部穿進。
3. 把豎送刻度設為 0。 但是，Z035 機種 16 針時，豎送布刻度設為 1.5mm。

★ Attachment for snaps (Z037)

★釘子母釦附件（Z037）

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



(INSTALLATION)

Remove the button clamp mechanism assembly and the feed plate. Set both the crosswise feed and lengthwise feed graduated plates to "4 mm". Install snap clamp feed plate ❶ in the way that the needle drops evenly at four corners of its square opening. Install snap attachment assembly ❷ on the machine, place a snap on the snap clamp jaw levers and make sure that the needle drops accurately in each hole in the snap. If necessary. loosen hex head screws ❸ and adjust the position accurately.

Lastly, make sure that the concave section on the bottom face of snap clamp slide guide ❹ accurately matches the convex section on snap clamp feed plate ❶. Replace thread guide No. 3 ❺.

(安裝方法)

卸下抓釦裝置和布壓腳下板，橫送布刻度和豎送布刻度設定為 4mm 以後，安裝子母釦用下布壓板❶，讓針均勻地落到四角孔裡。

然後，在子母釦抓腳抓住子母釦的狀態，安裝上子母釦抓釦裝置❷，讓機針正確地落到釦孔裡。

如果落針不正確的話，請擰鬆六腳螺絲❸進行調詳。

最後，請確認下布壓板❶的凸形和子母釦用鈕釦導爪❹下面的凹形是否完全一致。

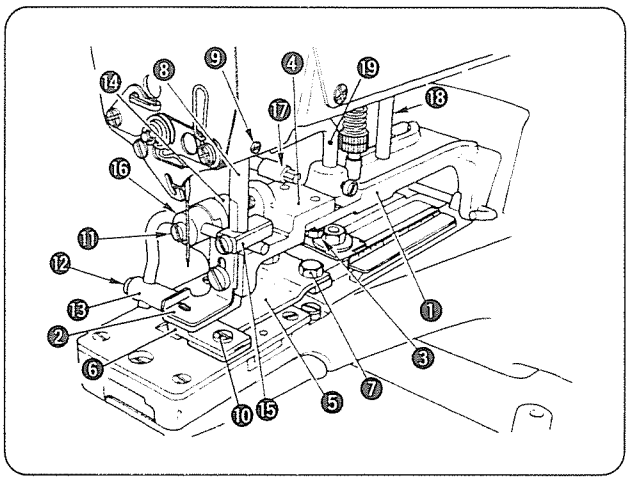
另外，第三導線器❺也換成子母釦用的。

★ Attachment for metal buttons (Z038)

★釘金屬釦附件（Z038）

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



(安裝方法)

卸下抓釦裝置和布壓腳下板，安裝金屬釦用抓釦裝置❶，擰鬆固定螺絲❸，前後移動抓爪安裝台❹，讓機針正好落在抓爪❷的落針溝的中間。另外，用固定螺絲❼固定金屬釦用布壓腳下板❺，讓機針正好落在壓腳下板❻的落針溝中。

把鈕釦壓開桿❽插進機架頭部的孔裡，然後用固定螺絲❾擰緊固定。

(使用方法)

1. 擰鬆固定螺絲❿，把布壓腳下板❻從抓爪❷的左端面拉進 1.0 ～ 1.5mm ，然後擰緊固定螺絲❿。
2. 安放鈕釦，擰鬆固定螺絲⓫和⓬，讓鈕釦壓腳⓭正好壓住鈕釦的中心。
3. 擰鬆固定螺絲，轉動軸環⓮進行調詳，讓鈕釦壓腳⓭的壓力在縫製中不讓鈕釦移動。
4. 把鈕釦壓腳打開凸輪⓯移動到使用方便的位置固定起來。

注意
1. 轉動軸環時，旋轉軸⓰在軸方向不能有鬆動。
2. 抓釦裝置上昇時，L型提昇桿凸輪⓱和抓爪安裝台❹不要相碰。

(INSTALLATION)

Remove both the button clamp mechanism assembly and the feed plate from the machine and install attachment ❶ in place. Loosen screws ❸ and adjust button clamp bracket ❹ to permit the needle to come down in the middle of the needle slot in metal button adaptor ❷. Attach button clamp feed plate ❺ using screws ❼ in the way that it permits the needle to come down in the middle of the needle slot in feed plate ❻. Insert the top end of button clamp stud ❽ into an opening in the jaw of the machine arm and fasten it by screw ❾.

(ADJUSTMENT AND OPERATION)

1. Loosen screw ❿, let feed plate ❻ recede 1.0 to 1.5 mm from the left end of button clamp jaw lever ❷ and retighten screw ❿.
2. Set a button in place, loosen screws ⓫ and ⓬and align metal button holding clamp ⓭ with the center of the button.
3. Metal button holding clamp ⓭ must give proper pressure to the button so that the button stays steadily in position while being sewn. Loosen a setscrew in thrust collar ⓮ and rotate the thrust collar until metal button holding clamp ⓭ provides proper pressure.
4. You may fix button clamp block ⓯ in a convenient position for operation.

Caution
1. **When you fix the thrust collar, ensure that button clamp rotating shaft ⓰ does not play axially in its bracket.**
2. **Adjust lifting hook ⓳ and stopper pin ⓲ so that L-shaped liting rod roller ⓱ does not come in contact with button clamp bracket ❹.**

22. MOTOR PULLEY AND BELT / 馬達皮帶輪和皮帶

(1) For this machine a single-phase or 3-phase 200 watts (1/4 HP) induction motor is used.
(2) A round leather belt (ø7x650 mm) is used.
(3) The sewing speed depends on the diameter of the motor pulley as listed below ;

（1）馬達使用單相、輸出功率 200W（1/4 馬力）的通用馬達。
（2）皮帶使用圓皮帶（ φ 7 × 650mm）。
（3）馬達皮帶輪和縫紉機轉速的關係如下表所示。

Hz	rpm	Motor pulley part No. 馬達皮帶輪的貨號	mm
50	1500	B7101372000	71
	1250	B7102372000	59.2
60	1500	B7102372000	59.2
	1300	B7103372000	51.3

★ The effective diameter of motor pulley is obtained by subtracting 1 mm from its outer diameter.
★ The motor must revolve in the counterclockwise direction when viewed from the motor pulley side. Take care not to let it run in the reverse direction.

★馬達皮帶輪的有效直徑是外徑減 1mm 。
★馬達的旋轉方向從馬達皮帶輪側看為反時針方向。請肴意方向不要弄反。

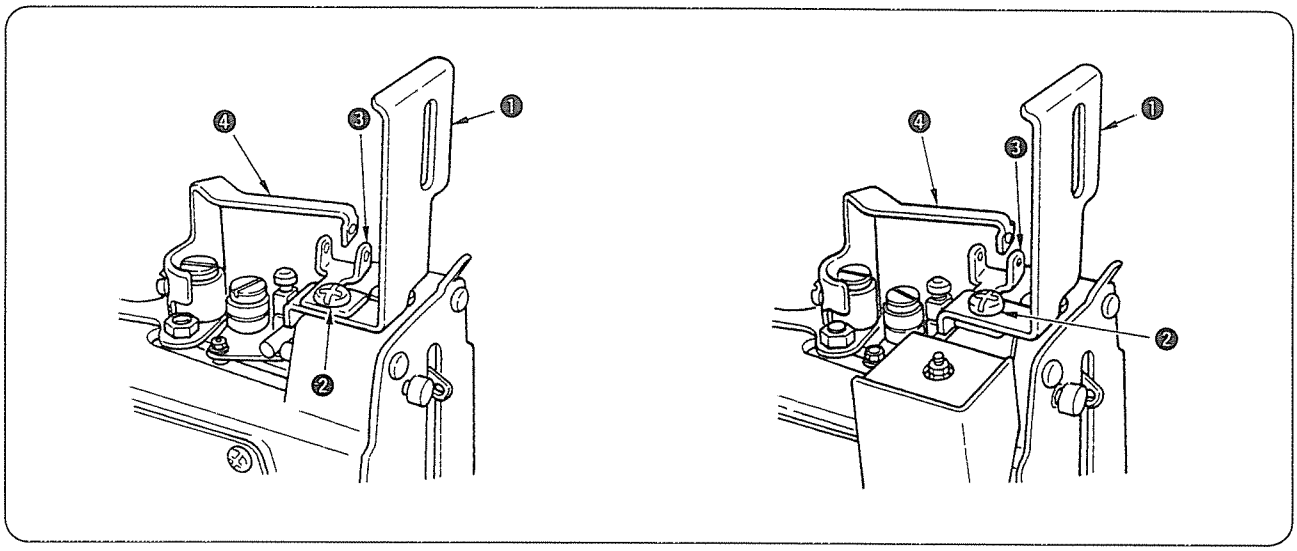
23. TROUBLES AND CORRECTIVE MEASURES

TROUBLES	CAUSES	CORRECTIVE MEASURES
1. Thread breakage	(1) The yoke slide does not move in the correct way.	○ Adjust the timing of the motion of the yoke slide at each end.
	(2) The thread tension post No. 2 fails to release the thread at correct timing.	○ Make the thread release timing slightly earlier.
	(3) The thread nipper catches the thread.	○ Adjust the position of the nipper bar block.
	(4) The needle does not enter the center of the holes in the button.	○ Adjust the button clamp jaw lever holder.
	(5) The needle is too thick for the diameter of the hole in the button.	○ Replace the needle by a thinner one.
2. Buttons are not sewn tightly.	(1) The yoke slide does not move in the correct way.	○ Adjust the timing of the motion of the yoke slide at each end.
	(2) The thread tension post No. 2 fails to release the thread at correct timing.	○ Make the thread release timing slightly later.
	(3) The thread tension post No. 2 does not give sufficient tension.	○ Tighten the tension nut of tension post No. 2.
	(4) The needle does not enter the center of the holes in the button.	○ Adjust the button clamp jaw lever holder.
	(5) The work pressing force is too high or too low.	○ Adjust the work pressing force properly.
3. The first stitch trails relatively long thread from the right side of the button.	The thread pull-off lever does not work properly.	○ Adjust the thread pull-off lever by the nipper bar block (rear).
4. Thread trimming failure in the state of stop-motion	(1) The thread tension post No. 2 fails to release the thread at correct timing.	○ Make the thread release timing slightly later to give more tension to the stitches.
	(2) The needle hits the edge of the holes in the button.	○ Adjust the button clamp jaw lever holder.
	(3) The button clamp assembly does not rise to the necessary height.	○ Provide a 12 mm clearance between the feed plate and the button clampjaw levers when rose.
	(4) The thread nipper fails to press the thread.	○ Adjust the nipper bar block.
	(5) The work pressing force is too high.	○ Adjust the work pressing force by the pressure adjusting nut.
5. Thread trimming failure	(1) The moving knife does not separate the thread on the fabric with its separation nail.	○ Adjust the position of the moving knife.
	(2) The needle does not enter the center of the holes in the button.	○ Adjust the button clamp jaw lever holders.
	(3) The last stitch skips.	○ Adjust the looper.
	(4) The moving knife thread separation nail is too high or too low.	○ Adjust the height of the moving knife thread separation nail.
6. The needle thread is cut in two places on the wrong side of the fabric.	(1) The moving knife is set in wrong place.	○ Adjust the position of the moving knife when the machine is in the stop-motion state.
	(2) The moving knife thread separation nail is too high or too low.	○ Adjust the height of the thread separation nail.
7. Button trails too long thread after thread trimming.	(1) Timing of the moving knife motion is wrong.	○ Adjust the position of the moving knife.
	(2) The button clamp assembly rises too much.	○ Reduce the button clamp lift down to 9 mm.

2. ATTACHING THE NEEDLE BAR COVER / 針桿罩的安裝方法

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



1. Loosen screw ❷ and remove tension adjusting take-up thread guide ❸.
2. Put needle bar cover ❶ under tension adjusting take-up thread guide ❸. Then attach tension adjusting take-up thread guide so that tension lever ❹ is brought to the center of tension adjusting take-up thread guide ❸ at the time of starting the machine.
3. Fix the cover with screw ❷.

If the machine is provided with a wiper magnet, install first the thread adjusting take-up thread guide on the wiper magnet mounting base and then attach the needle bar cover onto the take-up thread guide.

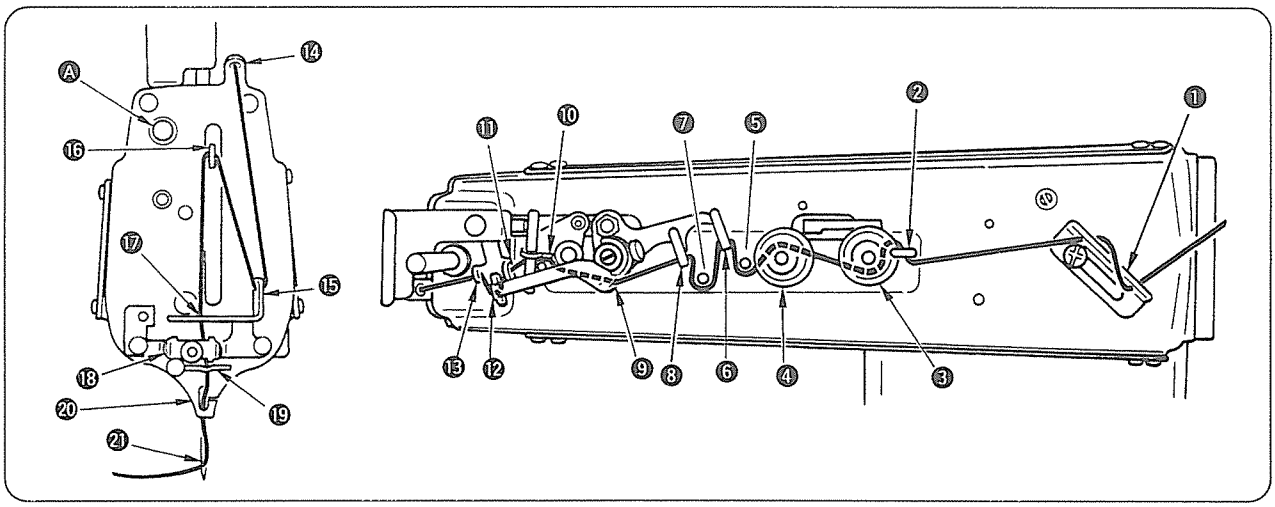
1. 擰鬆固定螺絲❷，卸下線調詳導線器❸。
2. 把針桿罩❶插進線調詳導線器❸下面，讓緊線撥桿❹在起動時移到線調詳導線器❸的中心。
3. 用固定螺絲❷固定起來。

如果裝有挑線電磁閥時，請把線調詳導線器安裝到挑線電磁閥安裝台座，再把針桿罩安裝在上面。

3. THREADING THE MACHINE HEAD / 上線穿線方法

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



Thread the machine head in the order of ❶ to ㉑ as shown in the illustration given above. Then, pass the thread through the needle eye from the front for approximately 60 to 70 mm as you depress nipper releasing knurled thumb nut Ⓐ.

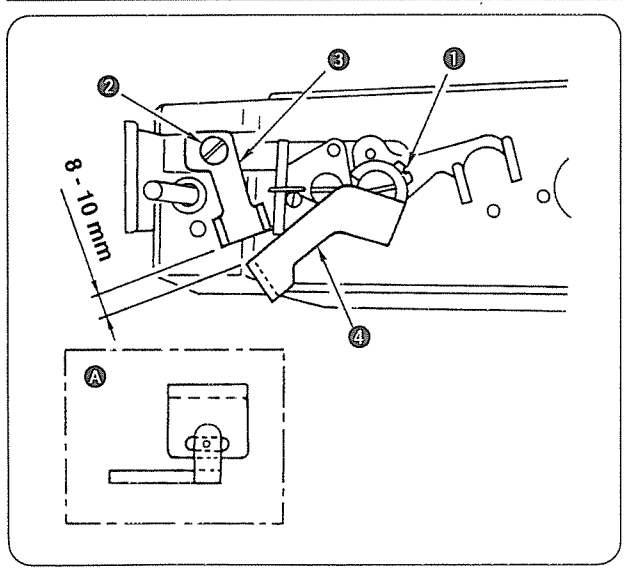
* The standard needle for -377 is a TQ x 1 #16 needle.
(The standard needle is TQ x 1 #20 needle for the -377 or TQ x 7 #18 needle for the -377)

如圖所示的順序進行穿線，從針孔的前側向後側按摔動螺母Ⓐ，把線拉出約 60 ～ 70mm 左右。
※ -377 的標準機針是 TQ × 1 #16 。
(-377 的標準機針是 TQ × 7 #20 ， -377 的標準機針是 TQ × 7 #18 。)

4. ADJUSTING THE TENSION LEVER / 緊線撥桿的調整

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



1. When the machine is in the stop-motion state, loosen screw ❶.
2. Then, retighten screw ❶ so that an end-to-end distance of 8 to 10 mm is provided between tension guide ❸ and tension lever ❹.

After the adjustment, make sure that the thread path is within the slot as illustrated in Fig. Ⓐ when the machine starts.
If the thread paths do not coincide with each other, loosen screw ❷ in the tension thread guide and adjust it properly.

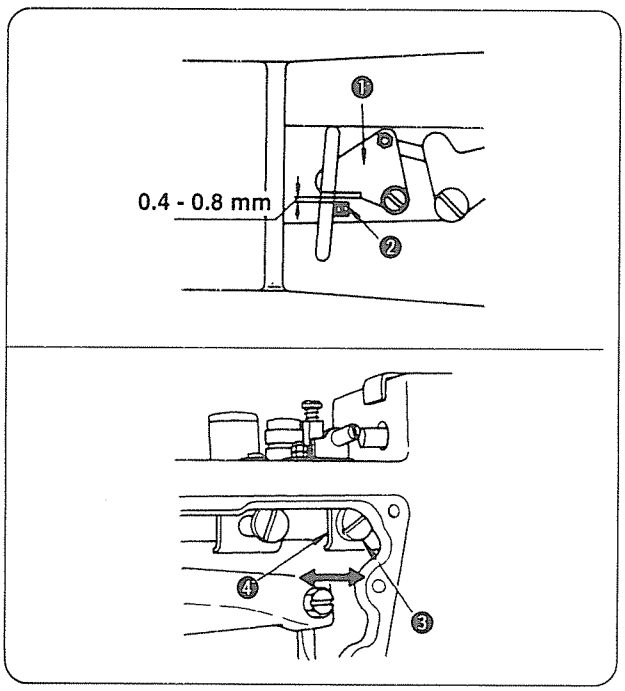
1. 在分離時，擰鬆固定螺絲❶。
2. 把線張力導線器❸的端面和緊線撥桿❹的端面距離 8 ～ 10mm ，然後擰緊固定螺絲❶。

調整後，請確認起動時線道如圖Ⓐ所示在長孔的範圍內。
如果不正確時，請擰鬆線張力導線器固定螺絲❷，進行調整。

5. ADJUSTING THE NIPPER / 拔針器的調整

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

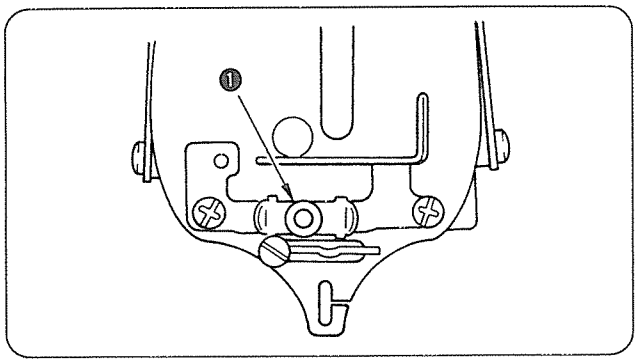
注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



1. Provide a 0.4 to 0.8 mm clearance between nipper block ❷ and nipper ❶ to prevent the nipper ❶ from holding the thread while the machine is in operation.
2. Loosen screw ❸ and move nipper bar block ❹ to the right or the left.

1. 運轉時，把拔針器❶的方塊❷和拔針器❶的間隙調整為 0.4 ～ 0.8mm ，不讓拔針器❶壓住機線。
2. 調詳方法是，擰鬆固定螺絲❸，左右移動拔針器活動滑塊❹。

6. ADJUSTING THE THREAD TENSION GUIDE ON THE FACE PLATE / 面板線張力器的調整



In the event that the machine fails to form a seam at the start of sewing and starts to form it after it has run a while, adjust the thread tension guide on the face plate if the aforementioned trouble cannot be corrected by adjusting the thread pull-off lever (refer to the Instruction Manual for the -373).

1. If the machine fails to form a seam at the start of sewing, reduce the thread tension by turning thumb nut ❶ (double nut).

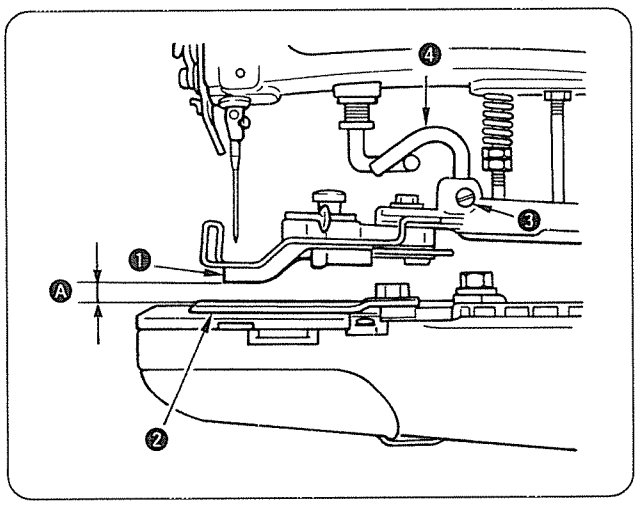
始縫時形成不了縫跡，從途中開始縫，調整線調詳撥桿（參照 -373 使用説明書）仍不能糾正時，進行調整。

1. 始縫不能形成縫跡時，請轉動旋鈕螺母❶（雙螺母），減弱線張力。

7. ADJUSTING THE HEIGHT OF THE BUTTON CLAMP UNIT / 抓釦裝置的高度

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

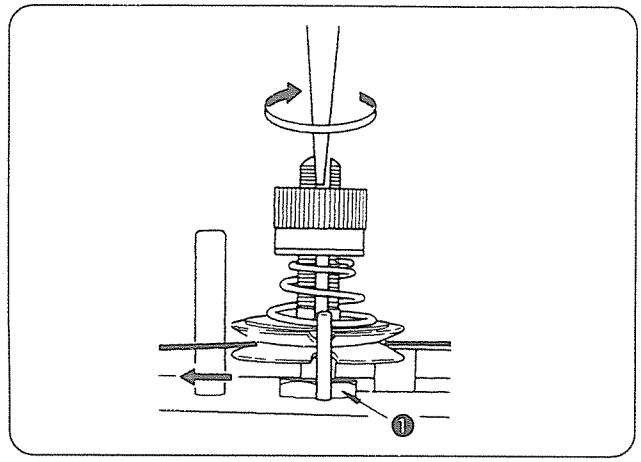
注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



1. At the stop-motion position, standard clearance Ⓐ provided between the bottom face of button clamp jaw lever ❶ and the top surface of feed plate ❷ is 8 mm (for ㄇ-shaped tacking and Z-shaped tacking) or 10 mm (for X-shaped tacking).
2. To adjust the height of the button clamp unit, loosen screw ❸ in the button clamp lifting hook and move button clamp lifting hook ❹ up or down.

1. 在斷開位置，鈕釦抓腳❶的底面和布壓腳下板❷上面的間隔Ⓐ， -377 的標準為8mm（ㄇ字、Z字），10mm（X字）。
2. 調整時，擰鬆抓腳提昇鉤固定螺絲❸，上下移動抓腳裝置提昇夠❹。

8. ADJUSTING THE TIMING OF THE THREAD TENSION RELEASE / 鬆線同步時間的調整



Drawing the thread in the direction of the arrow, gradually turn the driving pulley until you find a point at which the tension disk No. 2 rises to release the thread. At this moment, the standard height from the top surface of the needle bar upper bushing to the top end of the needle bar is 44 to 46 mm (54 to 56 mm when a TQ x 7 needle is used).

Loosen nut ①. Insert the blade of a screwdriver in the top slit of the tension post No. 2 and turn it in the direction of the arrow to decrease the height of the needle bar or in the reverse direction of the arrow to increase it.

沿箭頭方向拉機線，轉動驅動皮帶輪，有一個第二線張力盤浮起，機線迅速拔出的點。此時，從針桿上端塊上面到針桿上端的高度為 44 ～ 46mm 時為標準。

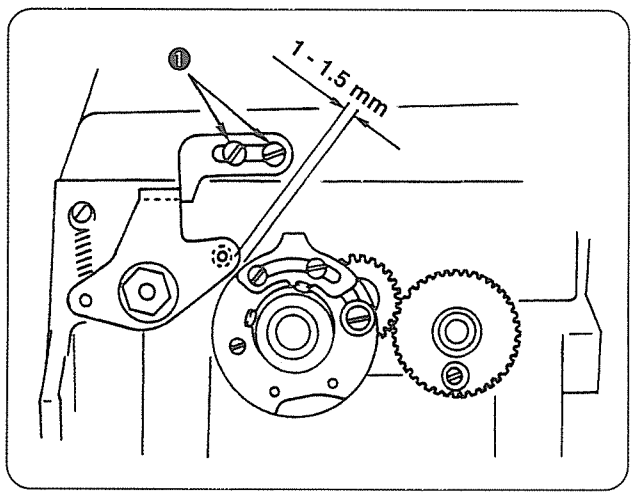
擰鬆螺母①，把螺絲刀插入第二線張力桿，沿箭頭方向轉動的話，針桿高度變低，向相反方向轉動，則變高。

9. KNOT-TYING MECHANISMS / 結線裝置

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。

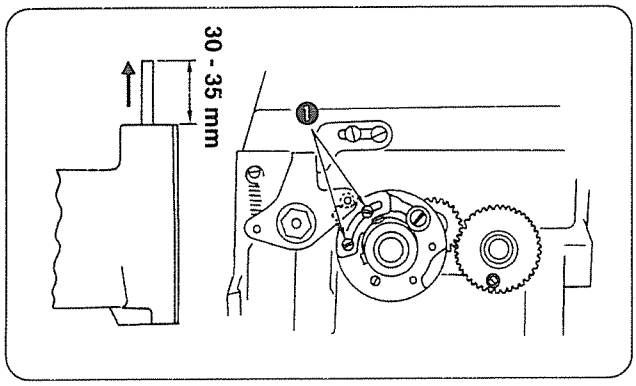
(1) Adjusting the knot-tying arm stopper / 結線曲軸擋塊的調整



Loosen screws ① and adjust so that a 1 to 1.5 mm clearance is provided between the outside periphery of the roller of the knot-tying arm and that of the stitch adjusting cam at the time of stop-motion.

分離時，結線曲軸的凸輪外周和針數調詳凸輪的外周之間的間隙約為1～1.5mm，擰鬆固定螺絲①進行調整。

(2) Adjusting the knot-tying notch / 結線打結的調整



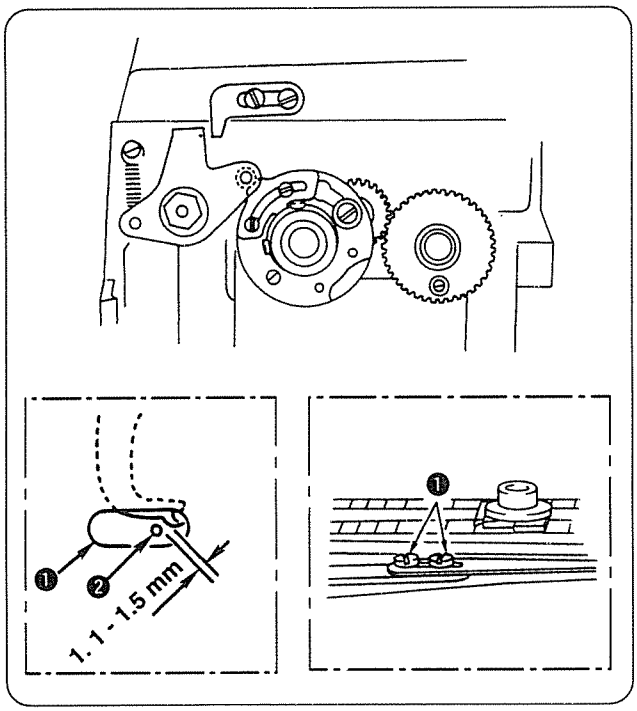
Loosen screws ❶ and adjust so that the roller of the knot-tying arm comes in contact with the knot-tying notch when the needle bar goes up at the fourteenth stitch as high as 30 to 35 mm (40 to 45 mm when a TQ x 7 needle is used) above the needle bar upper bushing.

If two knot-tying notches are to be installed (without crossover stitch), make the aforementioned adjustment at the 6th and 14th stitches.

在第14針針桿上昇時，針桿上金屬部件的端面為30～35mm（使用TQ×7機針時為40～45mm）時，請擰鬆固定螺絲❶，讓結線曲軸的凸輪與打結器相接觸。

打雙線結時（無連線），請調整第6針和第14針。

(3) Adjusting the knot-tying connecting plate / 結線連接板的調整



Loosen screws ❶ and adjust so that a clearance of 1 to 1.5 mm is provided between the needle ❷ and the knot tying plate ❸ when the roller of the knot-tying arm gets on the outmost periphery of the knot-tying notch.

(After the adjustment, ascertain that the needle does not come in contact with the knot-tying plate.)

結線曲軸的凸輪轉到打結器的最外周時，機針❷和結線板❸之間的間隙為1～1.5mm，請擰鬆固定螺絲❶，進行調整。

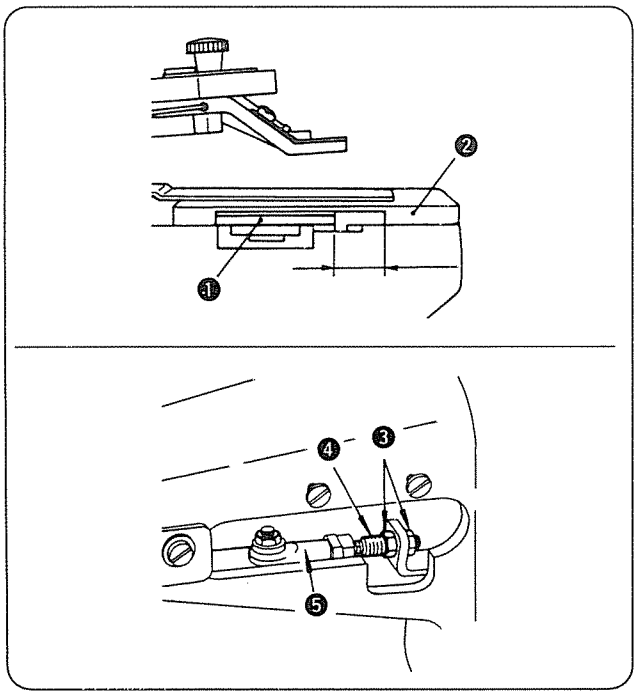
（調整後請確認機針和結線板不能相碰。）

10. AUTOMATIC THREAD TRIMMER / 切線裝置

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。

(1) Adjusting the position of the moving knife / 切線裝置



When the machine stops in the state of "stop-motion" and its button clamp assembly rests in the highest position, there must be a standard clearance of 10.5 to 12.5 mm between thread trimming connecting link (front) and the end face of the slit in the throat plate ❷. To adjust the aforementioned clearance, tilt the machine head, remove the oil shield, loosen two nuts ❸ and move connecting screw ❹ back or forth. When you tighten nuts ❸, ensure that joint ❺ stays in the horizontal position.

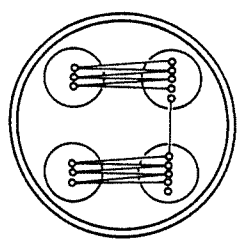
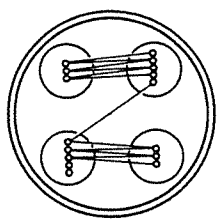
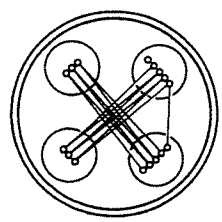
分離後壓腳上昇到最高處時，切線連接板（前）❶和針板❷槽溝端面的間隔標準為 10.5 ～ 12.5mm 。
調詳 10.5 ～ 12.5mm 時，請放倒縫紉機，卸下防油板，擰鬆螺母❸（2個），前後移動連結螺絲❹，進行調整。
另外，擰緊螺母❸時，請看意切線連結頭❺應基本保持水平。

11. OTHER ADJUSTMENTS / 其他調整

Refer to the "Instruction Manual for the -373 " for the adjusting procedure for other components.

其他調整的方法，請參照 -373 使用説明書。

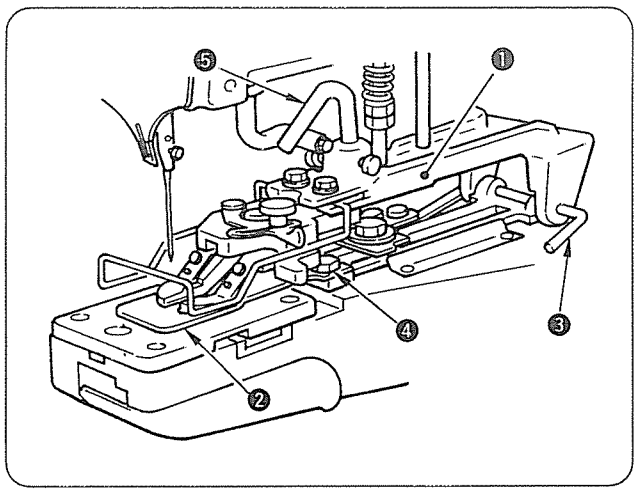
12. SUBCLASS MODELS / 派生機種

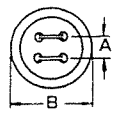
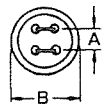
-377	-377 -10	-377 -11
8, 16, 32 stitches 8 、 16 、 32 針	8, 16, 32 stitches 8 、 16 、 32 針	8, 16, 32 stitches 8 、 16 、 32 針
		

13. ATTACHMENTS / 附件

WARNING :
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意 為了防止突然啟動造成人身事故，請關掉電源，確認馬達確實停止轉動後再進行。



Use 用途	Flat buttons / 平釦用	
	Large-size 大鈕釦	Medium-size 中鈕釦
-377	Z201	Z202
Schematic drawing 示意圖		
Remarks 備考	Button size : A : 3 to 6.5 mm B : ø20 to ø28 mm 鈕釦尺寸 A : 3～6.5 mm B : Φ20～Φ28 mm	Button size : A : 3 to 5 mm B : ø12 to ø20 mm 鈕釦尺寸 A : 3～5 mm B : Φ12～Φ20 mm

1. In order to install the attachment on the machine, you may have to remove button clamp mechanism ❶ or feed plate ❷.
2. Detach the snap ring from button clamp installing stud ❸, and you will be able to remove button clamp mechanism assembly ❶. Remove screw ❹, and you can remove feed plate ❷.

Caution **The only feature that makes the aforementioned attachment different from that of the MB-373NS is the button clamp lifting hook ❺.**

1. 安裝各附件時，有的機種不能拆卸抓釦裝置❶、布壓腳下板❷。
2. 抓釦裝置❶可以卸下安裝軸❸上的拉環，布壓腳下板❷可以卸下固定螺絲❹。

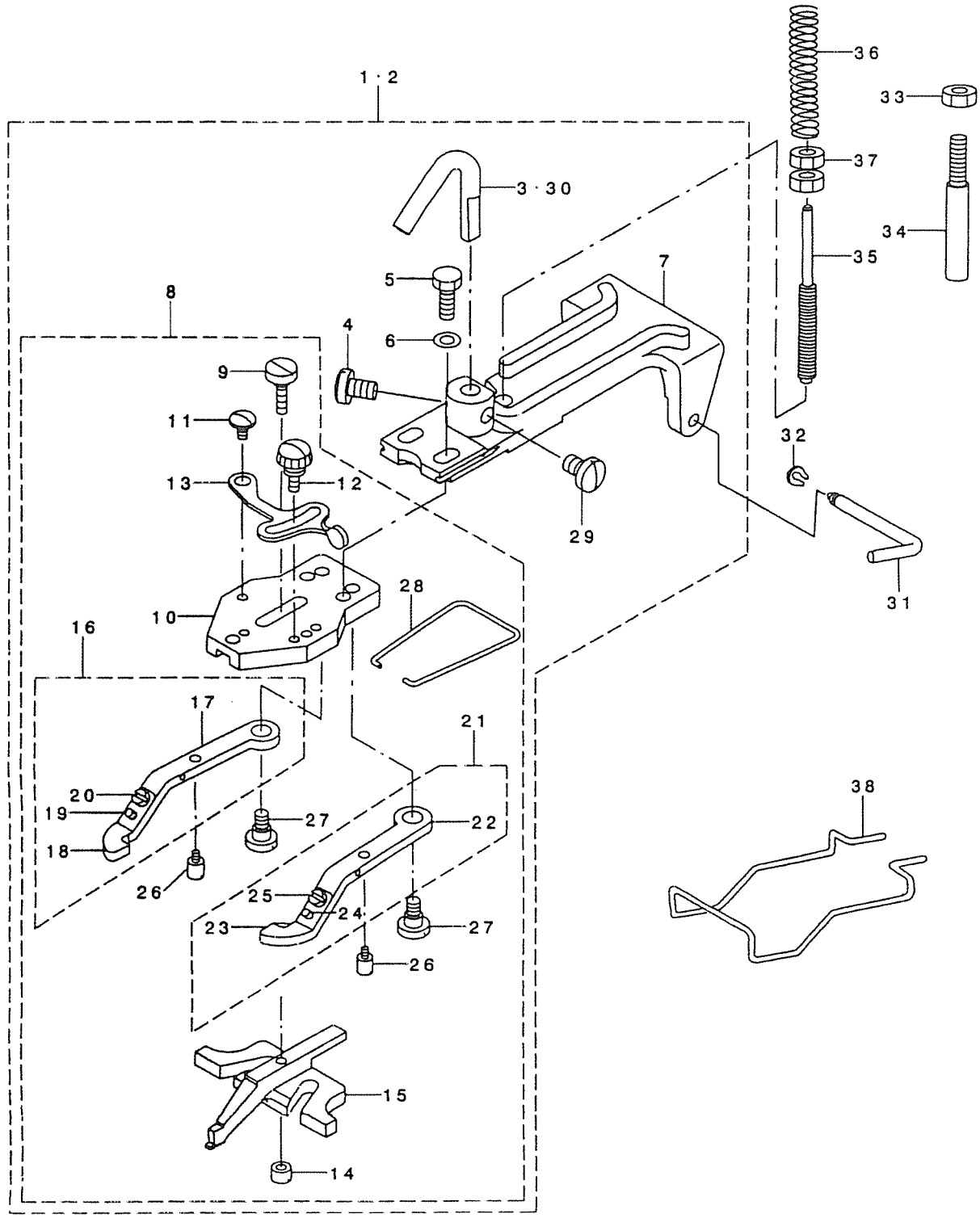
注意 -373 的附件不同之點示祇有抓釦裝置提昇鉤❺。

14. CAUSES OF TROUBLES AND CORRECTIVE MEASURES

Trouble	Cause	Corrective measure
1. Needle thread breaks after the machine stops.	① The tension lever has been improperly adjusted.	○ Properly adjust the tension lever.
	② Lifting amount of the button clamp jaw unit is excessive.	○ Adjust the lifting amount of the button clamp jaw lever to 8 mm (for ⊐-shaped tacking and Z-shaped tacking) or 10 mm (for X-shaped tacking).
	③ The nipper has been improperly adjusted. (The clearance is too small.)	○ Adjust the nipper with the nipper bar block.
2. The machine forms a seam after it has run for a while instead of forming it from the start of sewing.	① The thread pull-off lever has been improperly adjusted.	○ Properly adjust the rocker shaft of the thread pull-off lever.
	② Tension of the thread tension guide on the face plate is excessive.	○ Adjust the thread tension guide on the face plate so that it provides a lower tension.
3. The last back-tack stitch is poorly tensed.	① The tension lever has been improperly adjusted.	○ Properly adjust the tension lever.
	② Timing of the knot-tying plate is incorrect.	○ Advance the timing of the knot-tying plate. (Adjustment of the knot-tying notch)
	③ The nipper has been improperly adjusted. (The clearance is too large.)	○ Adjust the nipper with the nipper bar block.
4. Length of thread remaining, after thread trimming, on the wrong side of the material varies.	① Position of the moving knife is not correct.	○ Adjust the position of the moving knife when the machine completes stop-motion. (10 to 11 mm)
	② Lifting amount of the button clamp jaw unit is excessive.	○ Adjust the lifting amount of the button clamp jaw lever to 8 mm (for ⊐-shaped tacking and Z-shaped tacking) or 10 mm (for X-shaped tacking).

* Refer to the Instruction Manual for the -373 for causes and corrective measures for troubles other than those listed above.

一、钮钳机构部件/Button clamp mechanism components

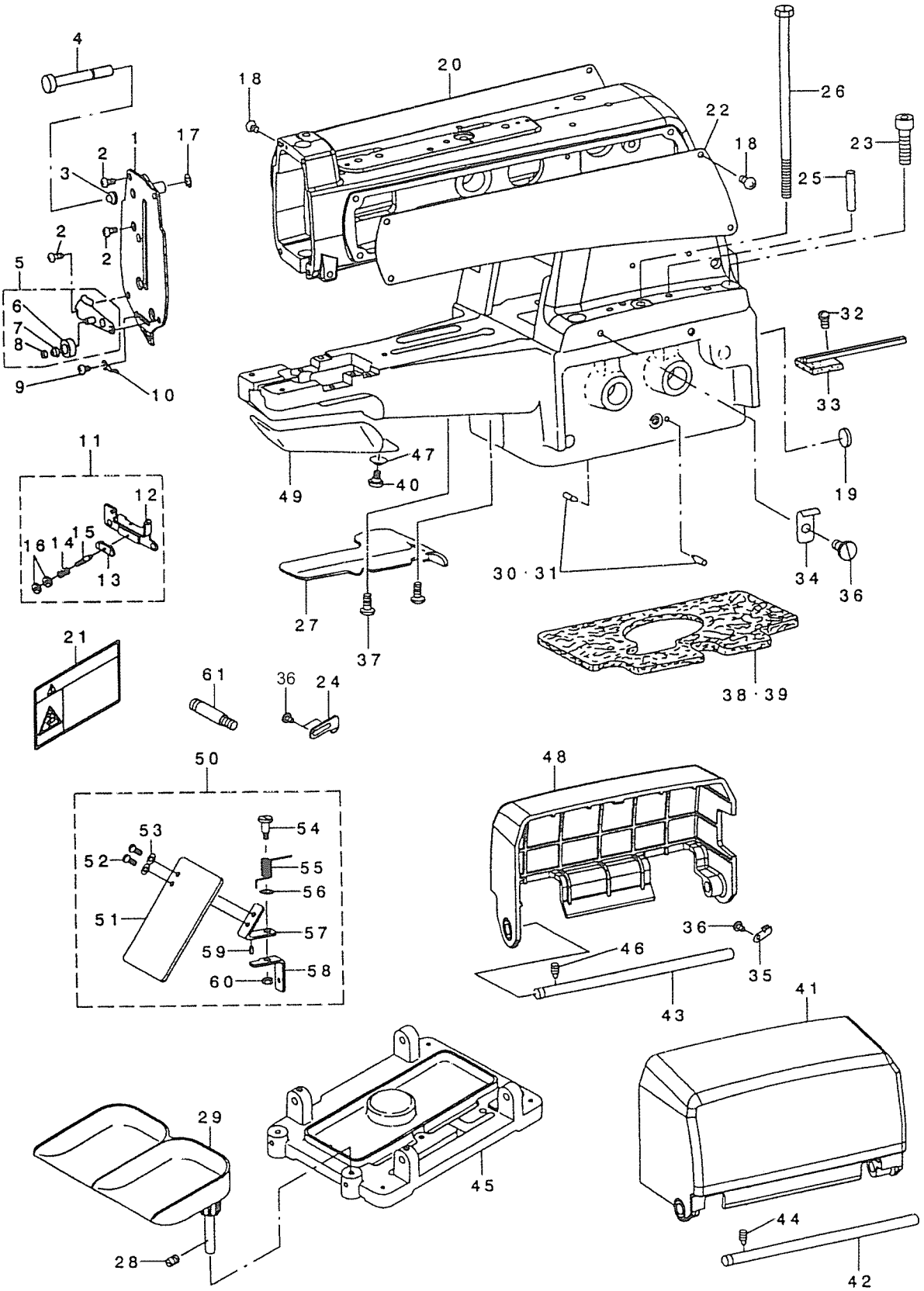


一、钮钳机构部件/Button clamp mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1	#01	B2547-377-0BA	平面钮扣钳组件	Flat button clamp asm.	1
2	#02	B2547-377-0A0	提升组件	Pick-up device asm.	1
3	#01	B2546-372-000	钮针提升杆	Button clamp lifting rod	(1)
4		SS-7150940-SP	固定提升杆的螺钉	Screw 15/64-28 L=9	(1)
5		SS-9621413-SP	用于钮钳座的螺钉	Screw 3/16-32 L=13.5	(2)
6		WP-0501016-SD	垫圈	Washer 5x10.5x1	(2)
7		B2542-372-00A	钮钳座	Button clamp holder	(1)
8		B2547-372-0C0	钮钳杆座组件	Jaw lever holder asm.	(1)
9		SD-0550301-SP	用于钮钳座的合叶螺钉(A)	Hinge screw D=5.5 H=1.8	(1)
10		B2547-372-000	钮钳杆钳座	Jaw lever holder	(1)
11		SD-0550181-SP	用于钮钳座的合叶螺钉(B)	Hinge screw D=5.5 H=1.8	(1)
12		B2549-372-000	用于止动杆的夹紧螺钉	Clamp screw A	(1)
13		B2548-372-000	钮钳止动杆	Snap fasterner clamp stop lever	(1)
14		B2553-372-000	合叶螺母	Nut	(1)
15		B2552-372-000	钮钳片	Button clamp slide	(1)
16		B2555-372-0A0	钮钳杆钳左组件	Button clamp lever jaw, left A	(1)
17		B2555-372-000	钮钳杆钳(左)	Button clamp lever jaw (left)	(1)
18		B2556-372-000	钮钳支撑弹簧(左)	Button holding spring, left	(1)
19		B2559-372-000	钮钳定位销	Button clamp locating pin	(1)
20		SS-7090410-SP	用于钮钳座弹簧的螺钉	Screw 9/64-40 L=3.5	(1)
21		B2557-372-0A0	钮钳杆钳右组件	Button clamp lever jaw, right	(1)
22		B2557-372-000	钮钳杆右钳(右)	Button clamp lever jaw (right)	(1)
23		B2558-372-000	钮钳支撑弹簧(右)	Button holding spring, right	(1)
24		B2559-372-000	定位销	Button clamp locating pin	(1)
25		SS-7090410-SP	用于钮钳座弹簧的螺钉	Screw 9/64-40 L=3.5	(1)
26		B2560-372-000	钮钳止动销	Button clamp stop pin	(2)
27		SD-0640391-TP	用于杆钳的合叶螺钉	Hinge screw D=6.35 H=3.9	(2)
28		B2561-372-000	钮钳弹簧	Button clamp spring	(1)
29		SS-7150940-SP	固定提升杆的螺钉	Screw 15/64-28 L=9	(1)
30	#02	B2546-377-000	钮钳提升钩	Pick-up device lifting hook	(1)
31		B2540-372-000	合叶销	Hinge pin	1
32		B2541-372-000	轴用挡圈	snap ring	1
33		NS-6150430-SP	用于钮钳塞销的螺母	Nut 15/64-28	1
34		B2543-372-000-A	钮钳塞销	Pick-up device stopper pin	1
35		B2544-372-000	钮钳调压杆	Button clamp pressure adjusting	1
36		B2545-372-000	调压弹簧	Pressure adjusting spring	1
37		NS-6660511-SP	用于钮钳调压杆的螺母	Nut 1/4	2
38		B3130-372-000-B	手指保护架	Finger guard	1

Note#01.....For- 373
#02 ....For- 377

二、机壳部件/Arm & miscellaneous cover components

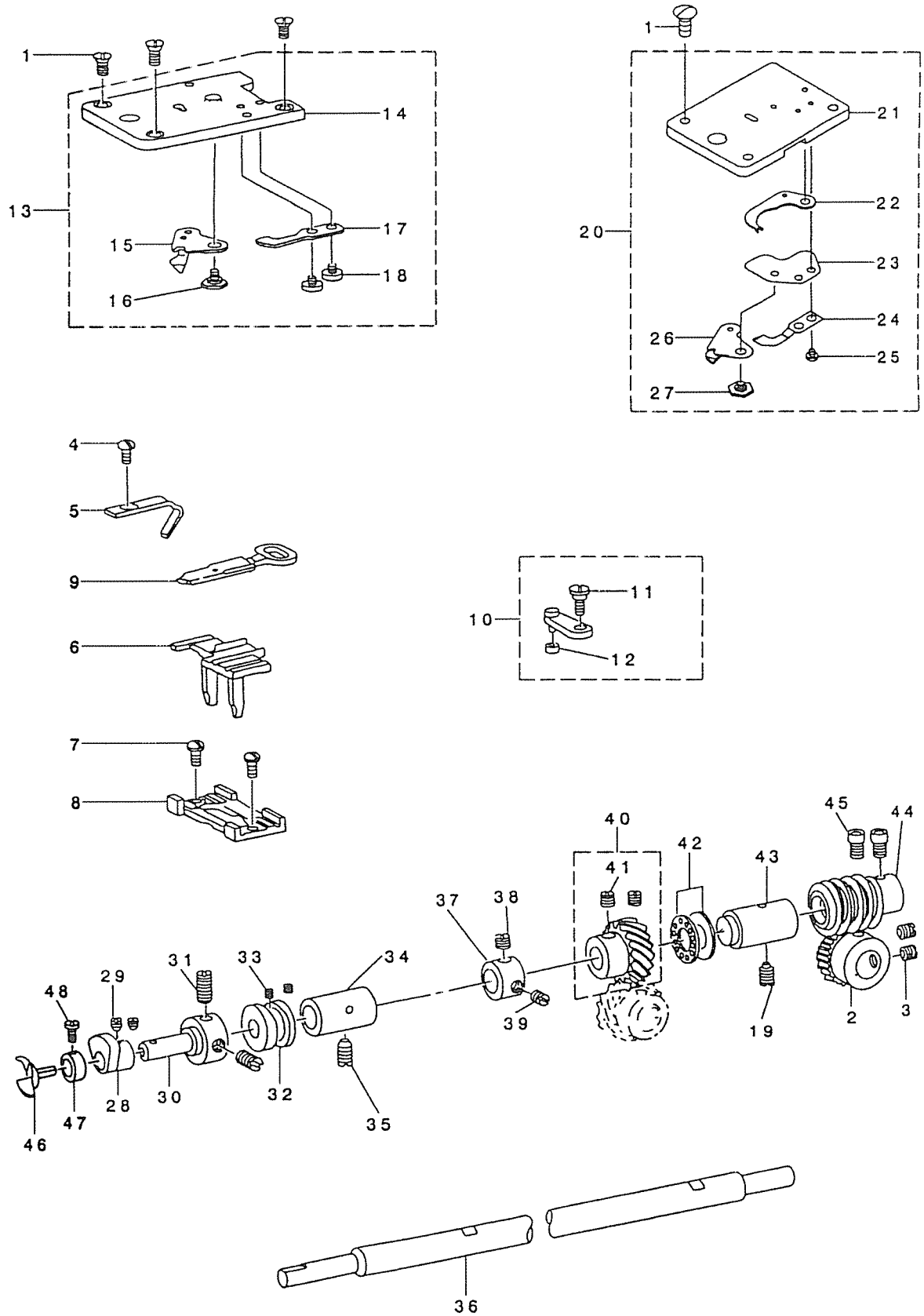


二、机壳部件/Arm & miscellaneous cover components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B260-38752	盖板	Face plate	1
2		SS-4120915-SP	螺钉	Screw 3/16-28 L=9	4
3		B3149-123-A00	弹簧	Tension spring	1
4		B3127-372-000	夹线螺栓	Nipper releasing stud	1
5	#01	260-01164	第三夹线导向装置	Thread tension guide NO.3 asm.	1
6		260-01404	第三夹线底座	Thread tension disc NO.3	(2)
7		260-01305	第三夹线弹簧	Thread tension spring NO.3	(1)
8		RE-0300000-K0	E型挡圈	E-ring 3	(1)
9		SS-7110340-SP	螺钉	Screw 11/64-40 L=3.2	1
10		B3108-372-000	第四线导向装置	Thread guide NO.4	1
11	#02	B3109-372-0A0	第三夹线总组件	Thread tension NO.3 asm.	1
12		178-02216	第三夹线调节基座	Tension adjusting base NO.3	(1)
13		101-29104	线调压板	Thread presser plate	(1)
14		B1136-850-000	夹线弹簧B	Tension spring B	(1)
15		250-02809	夹线螺栓	Thread tension stud	(1)
16		250-02808	夹线螺母	Thread tension nut	(2)
17		RE-0320000-K0	E型挡圈	E-ring 3.2	1
18		SS-4120915-SP	螺钉	Screw 3/16-28 L=9	4
19		100-04109	接地标记	Ground mark	1
20		260-12104	左盖板	Side plate, left	1
21		CM-3002001-B1	安全标牌	Safety label 12	1
22		260-12005	右盖板	side plate, right	1
23		SM-6083042-CH	螺钉	Screw M8 L=30	4
24	#02	B2712-377-000	止动板	Stopper	1
25		B1105-372-000	导销	Guide pin	2
26		B1128-372-000	连接螺栓	Set screw	1
27		B1119-373-000	底座油封	Bed oil shield	1
28		SS-8150710-SP	螺钉	Screw 15/64-28 L=7	1
29		1780-48458	钮扣盘组件	Button tray asm.	1
30		B2504-372-000	凸轮指示销	Cam indicating pin	2
31	#03	B2504-372-00A	凸轮指示销	Cam indicating pin	2
32		SS-7110840-SP	螺钉	Screw 11/64-40 L=7.8	1
33		B3503-372-0A0-A	油毡	Oil supply felt	1
34		B1127-372-000-A	盖板卡簧	side cover spring	2
35	#02	260-11809	盖板卡簧(左)	side cover spring, left	1
36		SS-7120640-SP	螺钉	Screw 3/16-28 L=6	2
37		SS-4110815-SP	螺钉	Screw 11/64-40 L=8	2
38	#03	B1104-372-A00	滴油毡 A	Oil drip felt (A) 5MM	1
39	#03	B1104-372-B00	滴油毡 B	Oil drip felt (B) 7MM	1
40		SD-0600271-SP	螺钉	Hinge screw D=6	1
41		260-11502	右滑轮盖	side cover,right	1
42		B1110-372-000	滑轮盖合叶杆	Side cover hinge shaft	1
43		B1110-377-000	滑轮盖合叶杆	Side cover shaft, left	1
44		SS-8150710-SP	螺钉	Screw 15/64-28 L=7	1
45		B1103-372-000	机器次底座	Machine sub-base	1
46		SS-8150710-SP	螺钉	Screw 15/64-28 L=7	1
47		WS-0650389-KP	弹性垫圈	Spring washer 6.5x14x17	1
48		260-11403	左盖	side cover, left	1
49		260-03608	底座活动盖	Looper cover	1
50		B3115-372-000	安全板组件	Safety plate asm.	1
51		B3120-372-000	安全板	Safety plate	(1)
52		SS-4110715-SP	螺钉	Screw 11/64-40 L=7	(2)
53		WP-0450801-SD	垫圈	Washer 4.5x10x0.8	(2)
54		SD-0601021-SP	合叶螺丝	Hinge screw D=6 H=10.2	(1)
55		139-43204	安全面板回位弹簧	Safety plate return spring	(1)
56		WP-0740516-SP	垫圈	Washer 7.4x11.8x0.5	(1)
57		B3121-372-000	安全板安装板	Safety plate installing plate	(1)
58		B3115-372-000	安全板安装基板	Safety plate installing base	(1)
59		PS-0200062-KH	塞销	Spring pin 2x6	(1)
60		NS-6110310-SP	螺钉	Nut 11/64-40	(1)
61		137-37507	悬浮螺钉	Suspension screw B	1

Note #01.....For- 373 #02.....For- 377 #03.....Selective partys

三、上轴机构部件/Looper shaft mechanism components

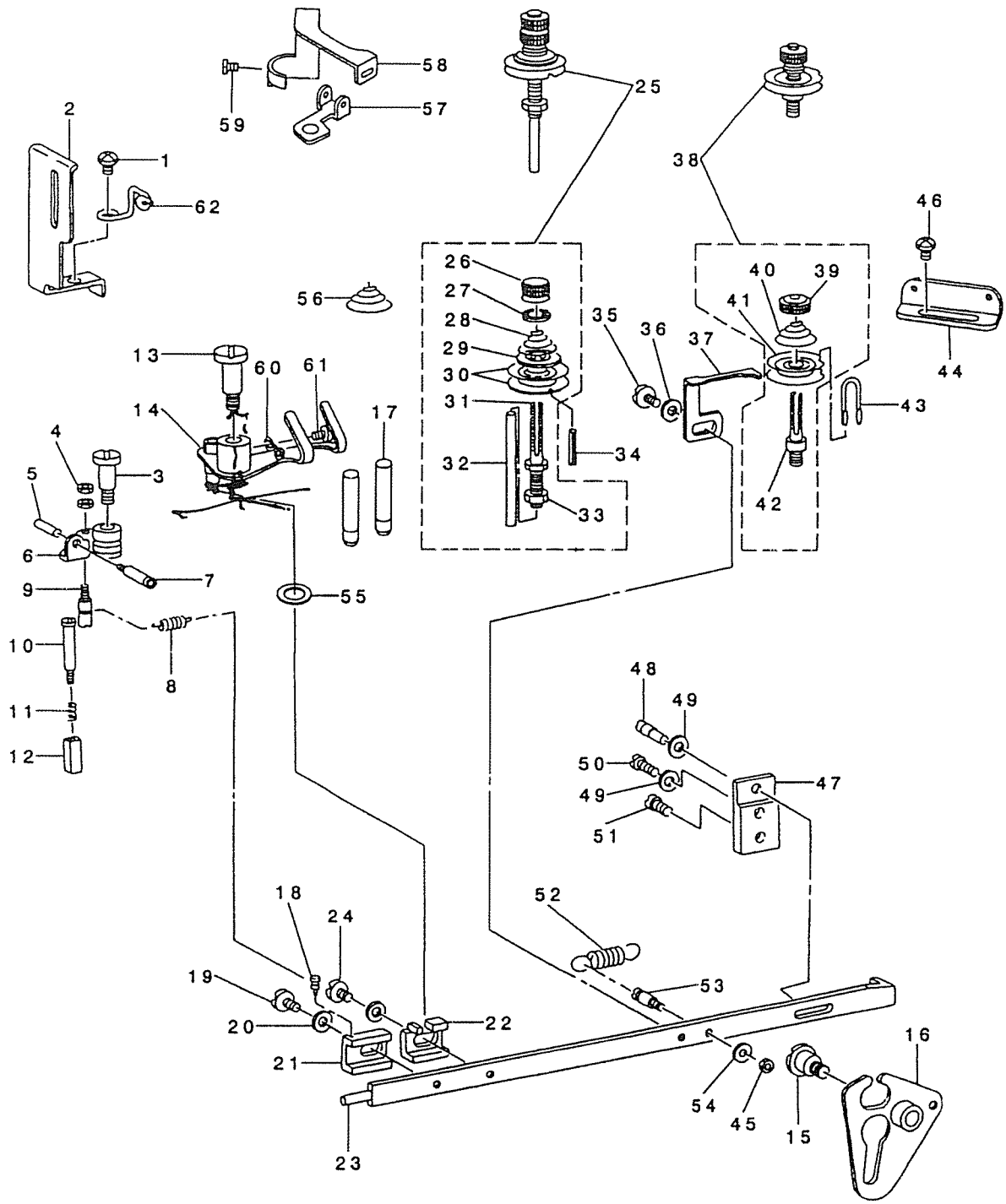


三、上轴机构部件/Looper shaft mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		SS-2110920-TP	螺钉	Screw 11/64-40 L=8.5	3
2		B1220-372-000	凸轮轴从动齿轮	Cam shaft driven gear	1
3		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	2
4		SS-7110840-SP	螺钉	Screw 11/64-40 L=7.8	1
5		B1242-373-000	导向线杆(打捆针导向器)	Needle guard	1
6		B1236-373-000	插入导向滑板(手指定位轭铁片)	Positioning finger yoke slide	1
7		SS-1110710-SP	螺钉	Screw 11/64-40 L=7.8	2
8		B1235-373-000	导向卡箍(压铁插孔)	Yoke slide insert	1
9		B1237-373-000	滑块(轭铁片)	Yoke slide	1
10		B1230-372-0A0	环形弹位杆(定位)	Loop positioning finger lever	1
11		SD-0640241-SP	螺钉	Hinge screw D=6.35 H=2.4	(1)
12		B1232-372-000	滚环	Loop positioning finger lever	(1)
13	#01	B1241-373-0B0	喉板组件	Throat plate asm.	1
14		B1241-373-000	喉板	Throat plate	(1)
15		B2406-373-000	可动刀组件	Moving knife asm.	(1)
16		SD-0600095-TH	合叶螺钉(旋转螺钉)	Hinge screw D=6 H=0.85	(1)
17		B2410-373-000	固定刀片	Counter knife	(1)
18		SS-7080310-SP	螺钉	Screw 1/8-44 L=3.0	(2)
19	#02	SS-8151150-SP	螺钉	screw 15/64-28 L=10.5	1
20	#01	B1241-377-0B0	喉板座组件	Throat plate set	1
21	#02	B1241-377-0A0	喉板	Throat plate asm.	(1)
22	#02	B2703-377-0A0	滚动线板	Thread bind plate asm.	(1)
23		B2702-377-000	滚动线板支撑	Thread bind support plate	(1)
24		B2410-373-000	固定刀	Counter knife	(1)
25		SS-7080310-SP	螺钉	Screw 1/8-44 L=3.0	(2)
26		B2406-373-0A0	可动刀	Moving knife asm.	(1)
27		SD-0600095-TH	螺钉	Hinge screw D=6 H=0.85	(1)
28		B1234-372-000	环形凸轮	Loop positioning finger cam	1
29		SS-8110410-TP	螺钉	screw 11/64-40 L=3.5	2
30		B1233-372-000	连接轴	cam & looper sleeve	1
31		SS-8110410-TP	螺钉	screw 15/64-28 L=4.0	2
32		B1228-372-000	后凸轮	Loop positioning finger cam re	1
33		SS-8110310-SP	螺钉	Screw 11/64-40 L=2.8	2
34		B1227-372-000	前轴套	Looper shaft bushing,front	1
35		SS-8151150-SP	螺钉	screw 15/64-28 L=10.5	1
36		B1219-372-000-A	下轴	Looper shaft	1
37		CS-1111019-SH	挡圈	Thrust collar D=11.11 W=10	2
38		SS-8660512-TP	螺钉	Screw 1/4-40 L=5	1
39		SS-8660512-TP	螺钉	Screw 1/4-40 L=5	1
40		B1224-372-0A0	上轴从动齿轮组件	Looper shaft driven gear asm.	1
41		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	(2)
42		B1215-372-A00	端面球轴承	Thrust ball bearing	1
43		B1222-372-000	轴套(后)	Looper shaft bushing, rear	1
44		B1221-372-000	从动蜗轮	Driven worm gear	1
45		SS-6660712-TP	螺钉	Screw 1/4-40 L=7.0	2
46		B1239-372-000	钩圈	Looper	1
47		CS-0790721-TH	挡圈	Thrust collar D=7.94 W=7	1
48		SS-7090620-TP	螺钉	Screw 9/64-40 L=6.1	1

Note #01.....For- 373 #02.....For- 377

四、绕线和过线部件/Nipper & tension parts components

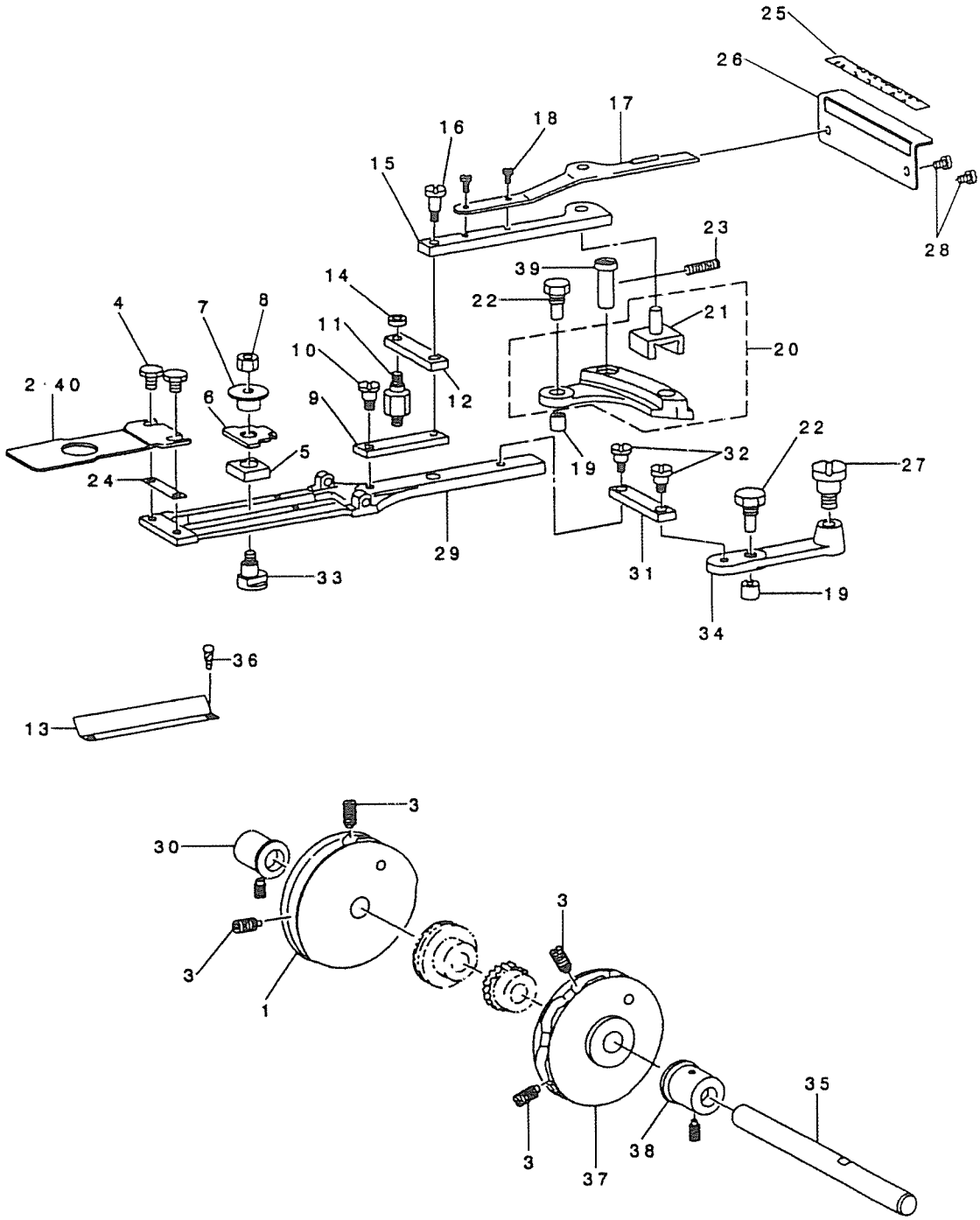


四、绕线和过线部件/Nipper & tension parts components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		SS-4150915-SP	螺钉	Screw 15/64-28 L=9	1
2		B1421-372-000	针杆护罩	Needle bar guard	1
3		SD-0791271-SP	螺钉	Hinge screw D=7.94 H=12.7	1
4		NS-6080210-SP	螺母	Nut 1/8-44	2
5		B2035-372-000	放线螺母	Nut	1
6		260-00950	导线装置	Nipper compl.	1
7		B2034-372-000	放线螺栓	Thread releasing screw stud	1
8		B2037-372-000	夹线杆底座弹簧	Nipper bar block spring	1
9		B1236-372-000	夹线杆底座弹簧螺钉	Nipper bar block spring screw	1
10		SD-0402001-TP	螺钉	Hinge screw D=4 H=20	1
11		B2029-372-000	夹线座弹簧	Nipper block spring	1
12		B2028-372-000	夹线座	Nipper block	1
13		SD-0791503-SP	螺钉	Hinge screw D=7.94 H=15	1
14		260-01560	引线杆组合	Thread pull-off lever asm.	1
15		SD-0790802-SP	驱动杆螺栓	Hinge screw D=7.94 H=8	1
16	#01	260-00455	夹线杆驱动杆设备	Nipper bar actuating lever asm.	1
17		B2024-372-000-A	L形导线钩	Thread guide pin	2
18		B2012-372-000	夹线杆底座弹簧销	Nipper bar block spring pin	1
19		SS-6120930-TP	螺钉	Screw 3/16-28 L=9	1
20		WP-0501016-SD	垫圈	washer 5x10.5x1	2
21		B2011-372-000	夹线杆底座	Nipper bar block	1
22		B2010-372-000	夹线杆底座(后)	Tension lever rocking piece	1
23		260-01909	夹线杆	Nipper bar	1
24		SS-6120930-TP	螺钉	Screw 3/16-28 L=9	1
25	#02	B2019-372-0A0	2号夹线杆组件	Tension post asm. NO.2	1
26	#01	B3116-372-000	调节螺母	tension nut	(1)
27		229-214070	停转器	Rotation stopper	(1)
28	#02	B2021-372-000	2号夹线压力弹簧	Thread tension spring NO.2	(1)
29	#02	B3132-012-000	夹线提升垫片	Tension disc holder	(1)
30		B2016-372-000	夹线圆盘(夹线板)	Tension disc	(2)
31		B2019-372-000	2号夹线杆	Tension post NO.2	(1)
32		B2020-372-000	放压枢轴(松线辅钉)	Tension release pin	(1)
33		NS-6160520-SP	平衡轴螺母	Nut 1/4-24	(1)
34		PS-0300162-KH	夹线圆盘销	spring pin 3x16	1
35		SS-6120930-TP	螺钉	Screw 3/16-28 L=9	1
36		WP-0501016-SD	垫圈	washer 5x10.5x1	1
37		B2029-372-000	释压杆	Thread tension releasing lever	2
38		260-05157	1号夹线器组件	Thread tension asm.(NO.1)	1
39		B3125-012-000	夹线螺母	Thread tension nut	(1)
40		B2017-372-000	1号夹线弹簧	Tension spring NO.1	(1)
41		B2016-372-000	夹线圆盘	Tension disc	(2)
42		B2015-372-000	1号夹线器轴	Thread tnesion staff NO.1	(1)
43		B2014-372-000-A	导线钩	Thread guide pin	1
44		B2039-373-000	1号导线钩	Thread guide NO.1	1
45		NS-6080340-SP	螺母	Nut 1/8-44	1
46		SS-4150915-SP	螺钉	Screw 15/64-28 L=9	1
47		B2005-372-000	夹线杆滑块	Nipper bar bearing block	1
48		B2006-372-000	调节螺母	Adjusting screw	1
49		WP-0480856-SP	垫圈	Washer 4.8x8.4x0.8	2
50		SS-6121610-TP	螺钉	Screw 3/16-28 L=15.5	1
51		SS-6121050-SP	螺钉	Screw 3/16-28 L=9.5	1
52		B2008-372-000	2号钳杆弹簧	Thread tension spring NO.2	1
53		B2007-372-000	夹线杆弹簧螺钉	Nipper bar spring screw	1
54		WP-0371016-SD	垫圈	Washer 3.7x8x1	1
55		135-07504	垫圈	Washer	1
56		B3114-232-000	2号夹线弹簧	Thread tension spring NO.2	1
57	#02	B2715-377-000	导线钩	Thread guide	1
58	#02	B2716-377-000	杠杆	Lever	1
59	#02	SS-7090540-TP	螺钉	Screw 9/64-40 L=5	1
60	#01	B2040-373-000	导线钩	Thread guide	1
61	#01	SS-4090415-SP	螺钉	Screw 9/64-40 L=4	1
62	#01	B2038-372-000	2号导线钩	Thread guide NO.2	1

Note #01.....For- 373 #02.....For - 377

五、送料盘部件/Feed plate components

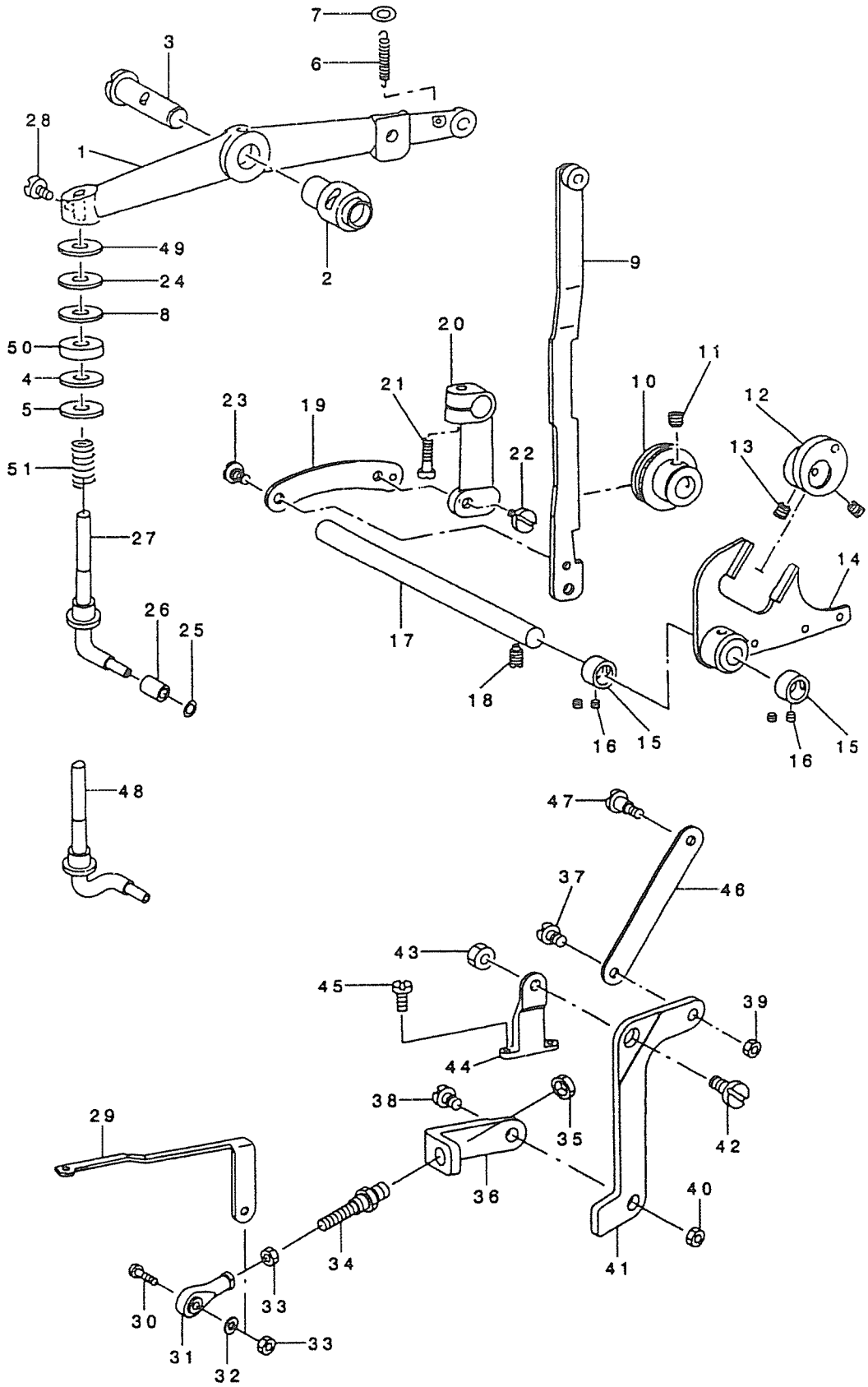


五、送料盘部件/Feed plate components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B2506-373-000-A	纵向送料凸轮	Longitudinal feed cam	1
2		B2529-373-000	小钮扣送料盘/板	Feed plate, small button	1
3		SS-8681412-TP	螺钉	Screw 9/32-28 L=13.5	4
4		SS-9120643-TP	螺钉	Screw 3/16-28 L=6	2
5		B2524-372-000	指示器销轴承座	Indicator pin bearing block	1
6		B2525-373-N00	交叉送料指示器	Crosswise feed indicator	1
7		B2526-372-000	交叉送料指示器销	Crossswise feed indicator pin	1
8		NS-6160520-SP	螺母	Nut 1/4-24	1
9		B2518-372-000-A	滑板连接杆	slide plate connecting link A	1
10		SD-0640481-SP	合叶螺钉	Hinge screw D=6.35 H=9.6	1
11		B2521-372-000	双头螺栓	Stud	1
12		B2519-372-000	中部连接杆	Intermedi connecting link	1
13		B2528-372-000-A	交叉送料刻度盘	Crosswise feed graduated plate	1
14		NS-6120630-SP	螺母	Nut 3/16-28	1
15		B2513-372-000	手柄及指示器弹簧手柄	Indicator spring connecting link	1
16		SD-0640961-SP	合叶螺钉	Hinge screw D=6.35 H=9.6	1
17		B2515-372-000	手柄及指示弹簧	Handle & indicator spring	1
18		SS-4090615-SP	螺钉	Screw 9/64-40 L=6	2
19		B2507-372-000	凸轮滚辗	Cam roll	2
20		B2511-372-0A0	纵向送料杆滑块组件	Lengthwise feed lever asm.	1
21		B2512-372-000	纵向送料轴滑块	Lengthwise feed lever slide block	(1)
22		B2508-372-000	凸轮滚辗螺栓	Cam roll screw stud	2
23		SS-8152030-SP	垫圈	Screw 15/64-28 L=20	1
24	#1	B2717-377-000	隔离板	Spacer	1
25		B2563-372-000	纵向送料刻度盘	Lengthwise feed graduated plate	1
26		B2564-372-000	纵向送料刻度盘底座	Plate base	1
27		SD-0791051-SP	螺钉	Hinge screw D=7.94 H=10.5	1
28		SS-4120615-SP	螺钉	Screw 3/16-28 L=6	2
29		B2522-373-000-A	滑板滑床板	Feed plate	1
30		B2503-372-000	凸轮轴左轴衬	Cam shaft bushing, left	1
31		B2519-372-000	十字形送料连接杆	Intermedi connecting link	1
32		SD-0640481-SP	螺钉	Hinge screw D=6.35 H=4.8	2
33		B2523-372-000	合叶螺钉	Hinge screw for crosswise feed	1
34		B2510-372-000-A	交叉送料杆	Crosswise feed lever	1
35		B2501-372-000-A	凸轮轴	Cam shaft	1
36		B1161-227-000	铆钉	Rivet	2
37		B2505-373-000-A	交叉送料凸轮	Lateral feed cam.	1
38		B2502-372-000	凸轮轴右轴衬	Cam shaft bushing, right	1
39		B2509-372-000-A	杆销	Feed stud	1
40		B2529-373-B00-A	中等规格钮扣送料盘/板	Feed plate medium size button	1

Note #01.....For -377

六、钮钳提升部件/Button clamp lifter components

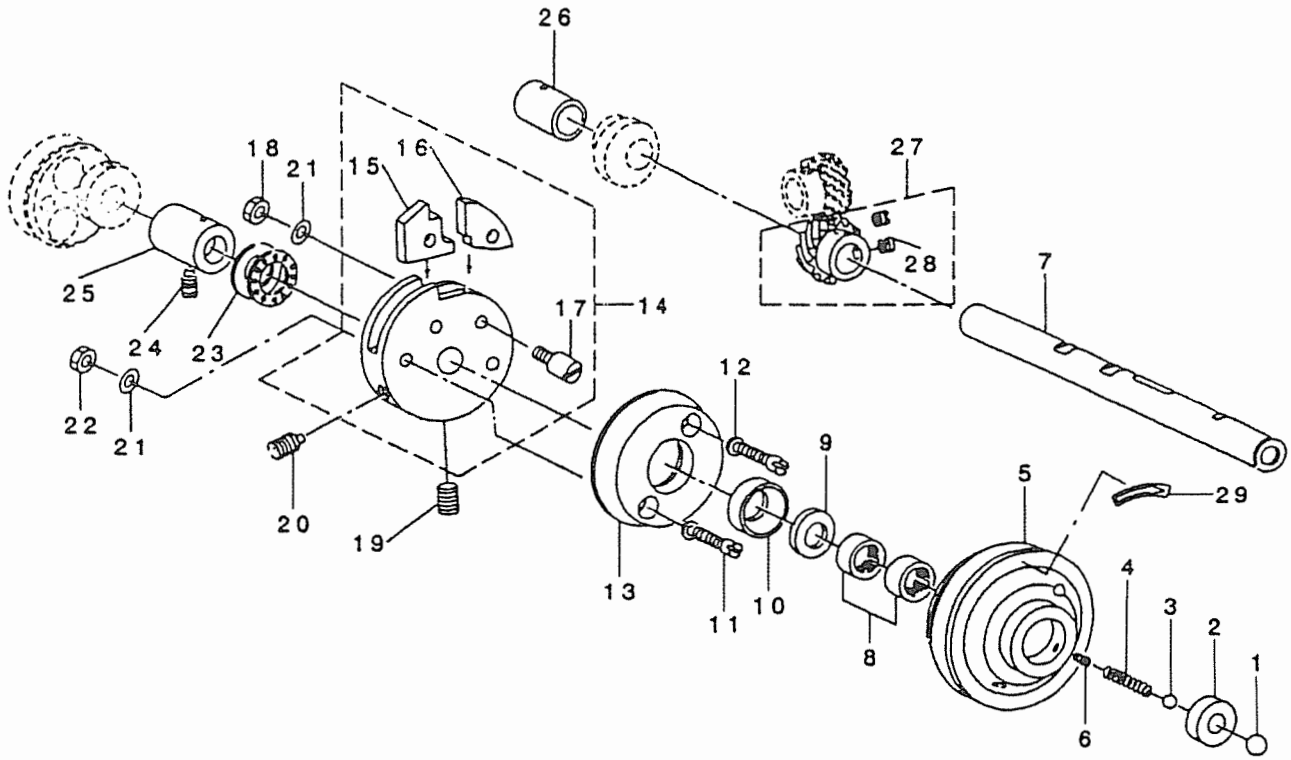


六、钮钳提升部件/Button clamp lifter components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B4412-373-000-A	钮钳提升杆	Lifting lever	1
2		B1407-372-000	轴衬	Bushing	1
3		B1408-372-000	提升杆轴	Lifting lever shaft	1
4	#4	WP-0751576-SD	垫圈	Washer 7.5x19x1.5	2
5	#4	WP-0851846-SD	垫圈	Washer 8.5x22.0x1.8	2
6		B4419-372-000	夹线杆动作杆弹簧	Nipper bar actuating lever spring	1
7		B4418-372-000	垫圈	Washer	1
8	#3	WP-0704016-SP	垫圈	Washer 7x20x4	1
9		B4411-372-000	钮钳提升杆	Button clamp lifting link	1
10		B4410-372-000	滑动滚筒	sliding roller	1
11		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	1
12		260-03301	偏心轮组件	Eccentric cam asm.	1
13		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	2
14		B4401-372-000	杠杆啮合钮钳提升连杆驱动离心	Button clamp lifting link	1
15		CS-090816-SH	止推环(挡圈)	Thrust collar D=9.5 W=8	2
16		SS-8110410-TP	螺钉	Screw 11/64-40 L=3.5	4
17		B4404-372-000-A	固定螺丝曲(柄)轴杠杆轴	Lever shaft	1
18		SS-8151150-SP	螺钉	Screw 15/64-28 L=10.5	1
19		B4408-372-000	钮钳提升联结杆	Lifting link connecting link	1
20		B4406-372-000-C	啮合钮钳提升连接杆	Lifting plate guide rod	1
21		SS-6121610-TP	螺钉	Screw 3/16-28 L=15.5	1
22		SD-0640481-SP	合叶螺丝	Hinge screw D=6.35 H=4.8	1
23		SD-0640211-SP	合叶螺丝	Hinge screw D=6.35 H=2.1	1
24	#3	WP-0703516-SP	垫圈	Washer 7x20x3.5	1
25		WP-0480856-SP	垫圈	Washer 4.8x8.4x0.8	1
26		B4417-372-000	钮钳提升杆滚动	Button clamp lifting rod roll	1
27	#1	260-00653	钮钳提升杆	Button clamp lifting rod compl	1
28		SM-6061002-TP	螺钉	Screw M6 L=10	1
29		B2404-373-R00	前切线连接杆	Connecting link, front	1
30	#1	B2413-373-000	连接螺栓	Joint stud	1
31		B1632-180-000	送料调节连接体	Feed adjusting joint	1
32		WP-0510516-SD	垫片	Washer 5.1x7.5x0.5	1
33		NM-6050001-SP	螺母	Nut M5	2
34		B2412-373-000	连接螺钉	Connecting screw	1
35		NS-6680410-SP	螺母	Nut 9/32-28	2
36		B2503-373-000-A	后切线连接杆	Connecting link, rear	1
37		SD-0640323-TP	合叶螺丝	Hinge screw D=6.35 H=3.2	1
38		SD-0790402-TP	合叶螺丝	Hinge screw D=7.94 H=4	1
39		NS-6620310-SP	螺母	Nut 3/16-32	1
40		NS-6150310-SP	螺母	Nut 15/64-28	1
41		260-02006	切线杆	Thread trimming lever	1
42		SD-0790311-TP	合叶螺丝	Hinge screw D=7.94 H=3.1	1
43		NS-6110420-SP	螺母	Nut 11/64-40	1
44		B2405-373-000	切线杆底座	Thread trim lever base	1
45		SS-7111410-TP	螺钉	Screw 11/64-40 L=14	2
46		B2401-373-000	切线连杆	Thread trimming link	1
47		SD-0641322-TP	合叶螺丝	Hinge screw D=6.35 H=13.2	1
48	#2	B4416-377-0A0	钮钳提升组件	Lifting bar asm.	1
49	#3	WP-0704516-SP	垫圈	Washer 7x20x4.5	1
50		B4420-373-000	缓冲垫	cushion	1
51		D9219-555-B00	安全弹簧	Safety magnet	1

Note #01.....For - 373 #03.....Selective part #04.....Selective parts
#02.....For - 377 (Use of one part) (Use of one or two parts)

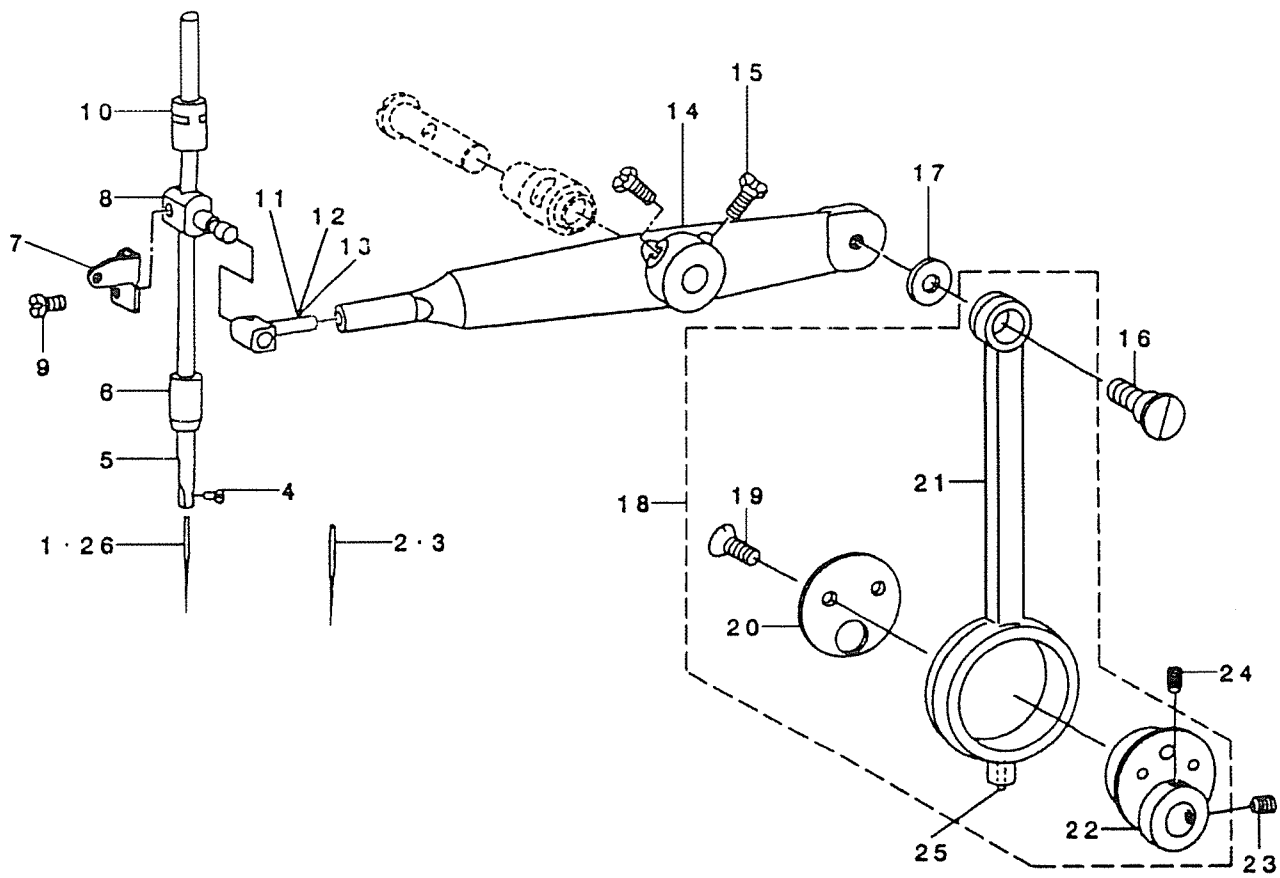
七、推针滑轮轴部件/Needle driving pulley shaft components



七、推针滑轮轴部件/Needle driving pulley shaft components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B1203-372-000	大滚珠	Ball large	1
2		B1204-372-000	主动轧辊支承/驱动转动承座	Pulley insert	1
3		B1246-372-000	小滚珠	Ball small	1
4		B1205-372-000	弹簧	Spring	1
5		B1202-372-000	驱针转筒滑轮	Needle driving pulley	1
6		SS-8110750-SP	螺钉	Screw 11/64-40 L=6.5	1
7		B1201-373-000	驱针滑轮轴	Needle driving pulley shaft	1
8		B1243-372-000	滚针轴承	Needle bearing	2
9		B1206-372-000	滑油绳	Grease retaining wick	1
10		B1207-372-000	密封垫	retaining washer	1
11		SS-6152440-SP	螺钉	Screw 15/64-28 L=23.5	2
12		WP-0621026-SP	垫圈	Washer 6.2x9.5x1	2
13		B1208-372-000	滑轮离合器圆盘驱针	Needle driving pulley clutch D	1
14		B1210-372-000	止动圆盘组件	Stop motion disc asm.	1
15		B1211-372-000	止动圆盘止动爪	Stop motion disc pawl (A)	(1)
16		B1212-372-000	止动圆盘销	Stop motion disc latch (B)	(1)
17		B1213-372-000	螺钉	Screw	(2)
18		NS-6150430-SP	螺母	Nut 15/64-28	2
19		SS-8707042-TP	定位螺钉	Screw 5/16-24 L=10.0	1
20		SS-8701782-TP	紧固螺钉	Screw 5/16-24 L=17.0	1
21		WS-0651310-KP	弹性垫圈	Spring washer 6.5x11x1.3	4
22		NS-6150430-SP	螺母	Nut 15/64-28	2
23		B1215-372-B00	滚动轴承	Thrust ball bearing	1
24		SS-8151150-SP	螺钉	Screw 15/64-28 L=10.5	1
25		B1216-372-000	滑轮轴右轴衬	Pulley shaft bushing, right	1
26		B1223-372-000	滑轮轴左轴衬	Pulley shaft bushing, left	1
27		B1217-372-0A0	从动齿轮组件	Driving gear asm.	1
28		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	(2)
29		CM-5002000-01	方向标签	Direction label.	1

八、针杆驱动机构部件/Needle bar driving mechanism components

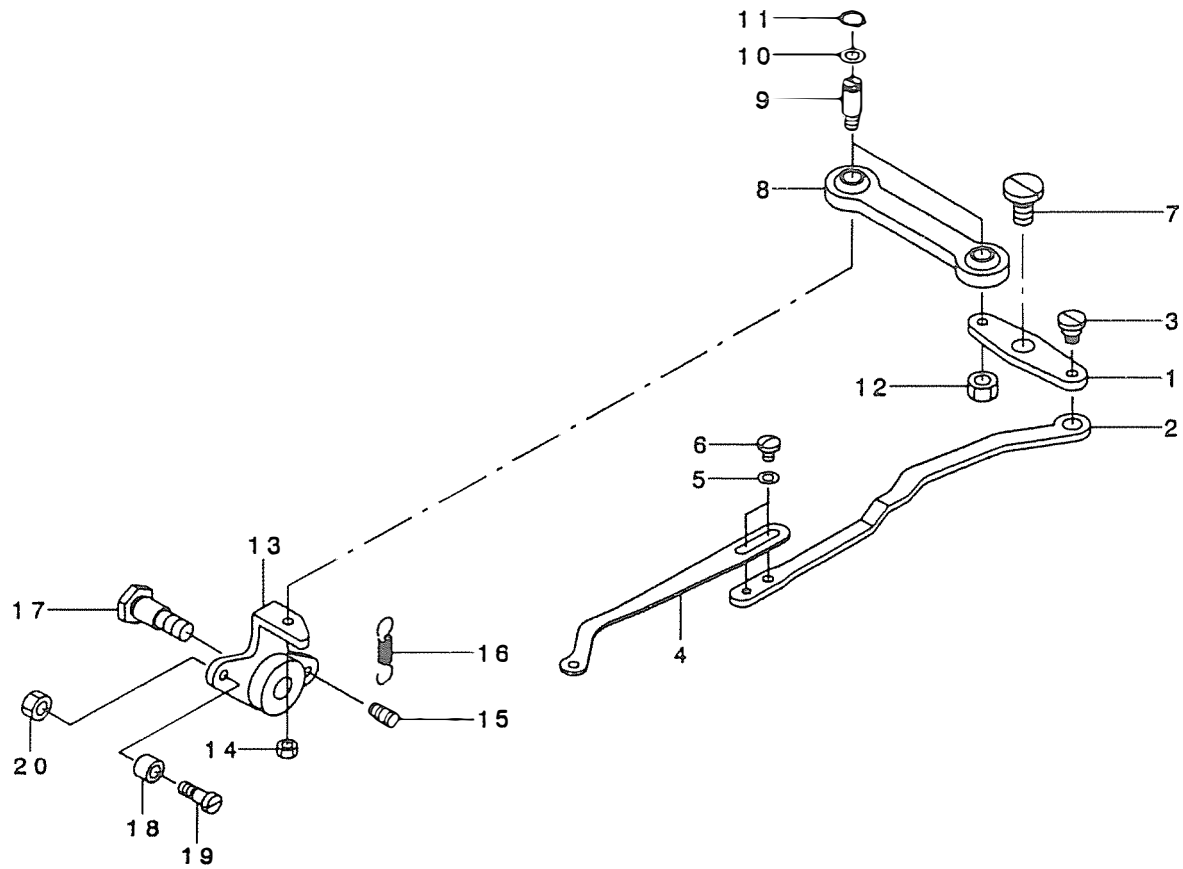


八、针杆驱动机构部件/Needle bar driving mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1	#01	MTQ-700B1800	机针	Needle TQx7 #16	1
2	#01	MTQ-700B2000	机针	Needle TQx7 #20	1
3	#02	MTQ-700B1800	机针	Needle TQx7 #18	1
4		SS-7080510-TP	螺钉	Screw 1/8-44 L=4.5	1
5		B1401-372-000-A	针棒	Needle bar	1
6		B1403-372-000-A	针棒下轴衬	Needle bar bushing lower	1
7		B3112-372-000	导线钩	Needle bar balance	1
8		B3113-372-000	针棒轴承座钳	Needle bar clamp	1
9		SS-6091210-TP	螺钉	Screw 9/64-40 L=12	1
10		B1402-372-000	针棒上轴衬	Needle bar bushing,upper	1
11	#03	B1406-372-000	针棒轴衬座	Needle bar bearing block	1
12	#03	B1406-372-00A	针棒轴衬座	Needle rod slide block	1
13	#03	B1406-372-00B	针棒轴衬座	Needle rod slide block B	1
14		B1409-372-000-B	针棒杆	Needle bar rocking pipe	1
15		SM-9061403-CP	螺钉	Screw M6 L=14	2
16		SD-0950806-SH	合叶螺丝	Hinge screw D=9.53 H=8	1
17		B1425-372-000	垫圈	washer 5x10.5x1	1
18		B1424-372-000	曲柄连杆组件	Crank rod asm.	1
19		SS-2110920-TP	螺钉	Screw /64-40 L=8.5	(2)
20		B1423-372-000	盖板	holder	(1)
21		B1424-372-000	连杆	rod	(1)
22		B1422-372-000	偏心凸轮	Eccentric cam	(1)
23		SS-8660612-TP	螺钉	Screw 1/4-40 L=6	1
24		SS-8660942-TP	螺钉	Screw 1/4-40 L=8.5	1
25		B1419-372-000	油线	Oil wick	1
26	#01	MTO-100B1600	机针	Needle TOx1 #16	1

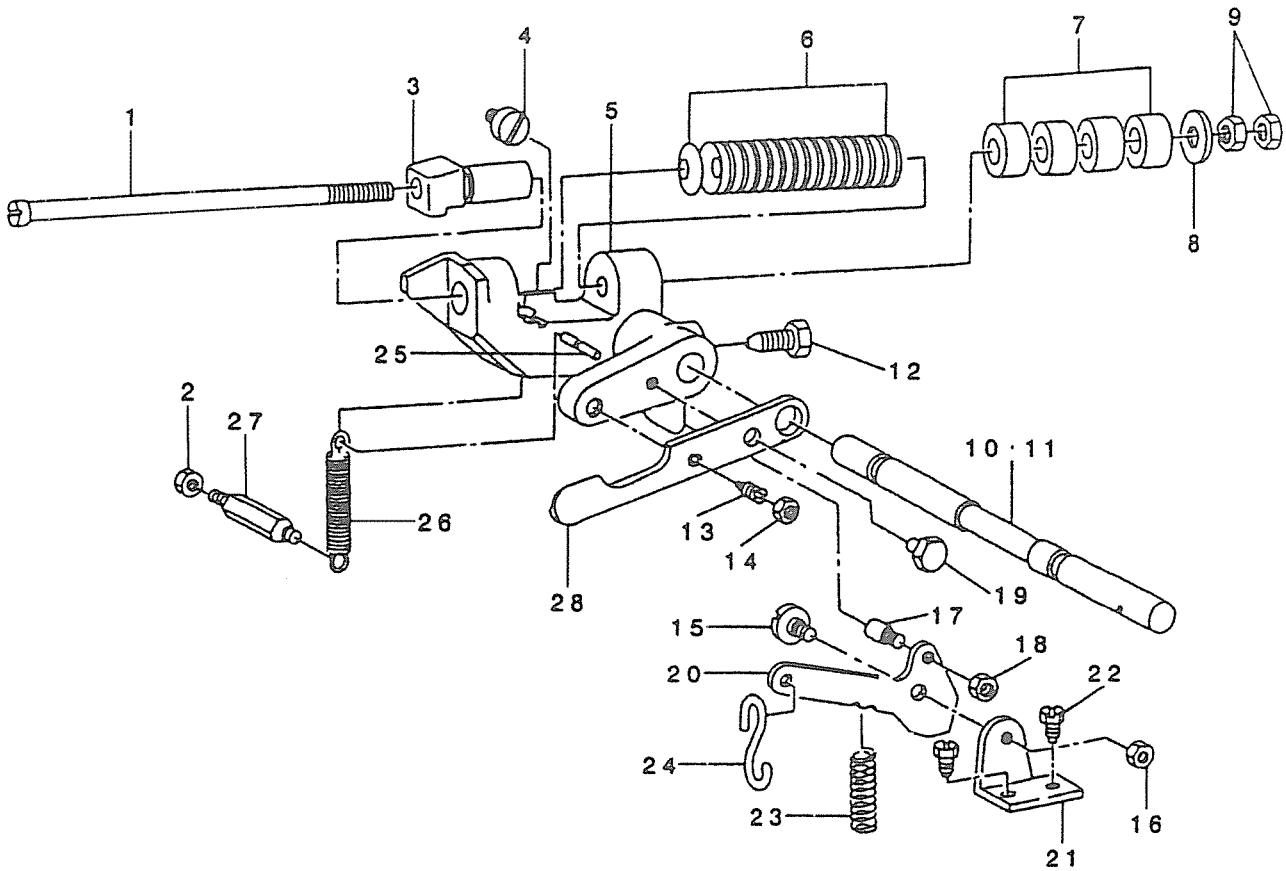
Note #01.....For -373
#02.....For -377
#03.....Selective parts

十一、捆线部件/Thread bind notch components



序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B2707-377-000	捆线杠杆	Thread bind lever	1
2		B2706-377-000	大联接板	Connecting plate.large	1
3		SD-064321-SP	螺钉	Hinge screw D=6.35 H=3.2	1
4		B2705-377-000	小联接板	Connecting plate.small	1
5		WP-0430800-SD	垫圈	Washer M4	2
6		SS-7090540-TP	螺钉	Screw 9/64-40 L=5	2
7		SD-0720331-SP	螺钉	Hinge screw D=7.24 H=3.3	1
8		D2509-282-A00	连接杆	Work camp foot ball link	1
9		B2708-377-000	捆线连接杆轴	Thread bind link shaft	2
10		WP-0621026-SP	垫圈	Washer 6.2x9.5x1	2
11		RC-0560711-KP	密封环	Retaining ring	2
12		NS-6110310-SP	螺母	Nut 11/64-40	1
13		B2709-377-0A0	捆线臂组件	Thread bind arm asm.	1
14		NS-6110310-SP	螺母	Nut 11/64-40	1
15		B1110-280-000	切线连接弹簧杆	Thread cutting link spring rac	1
16		B2711-377-000	弹簧	Spring	1
17		SD-0801021-TP	螺钉	Hinge screw D=8 H=10.2	1
18		B2718-377-000	滚筒	Roller	1
19		SD-0460571-CP	螺钉	Hinge screw D=4.6 H=5.7	1
20		NS-6110310-SP	螺母	Nut 11/64-40	1

九、止动机构部件/Stop motion mechanism components

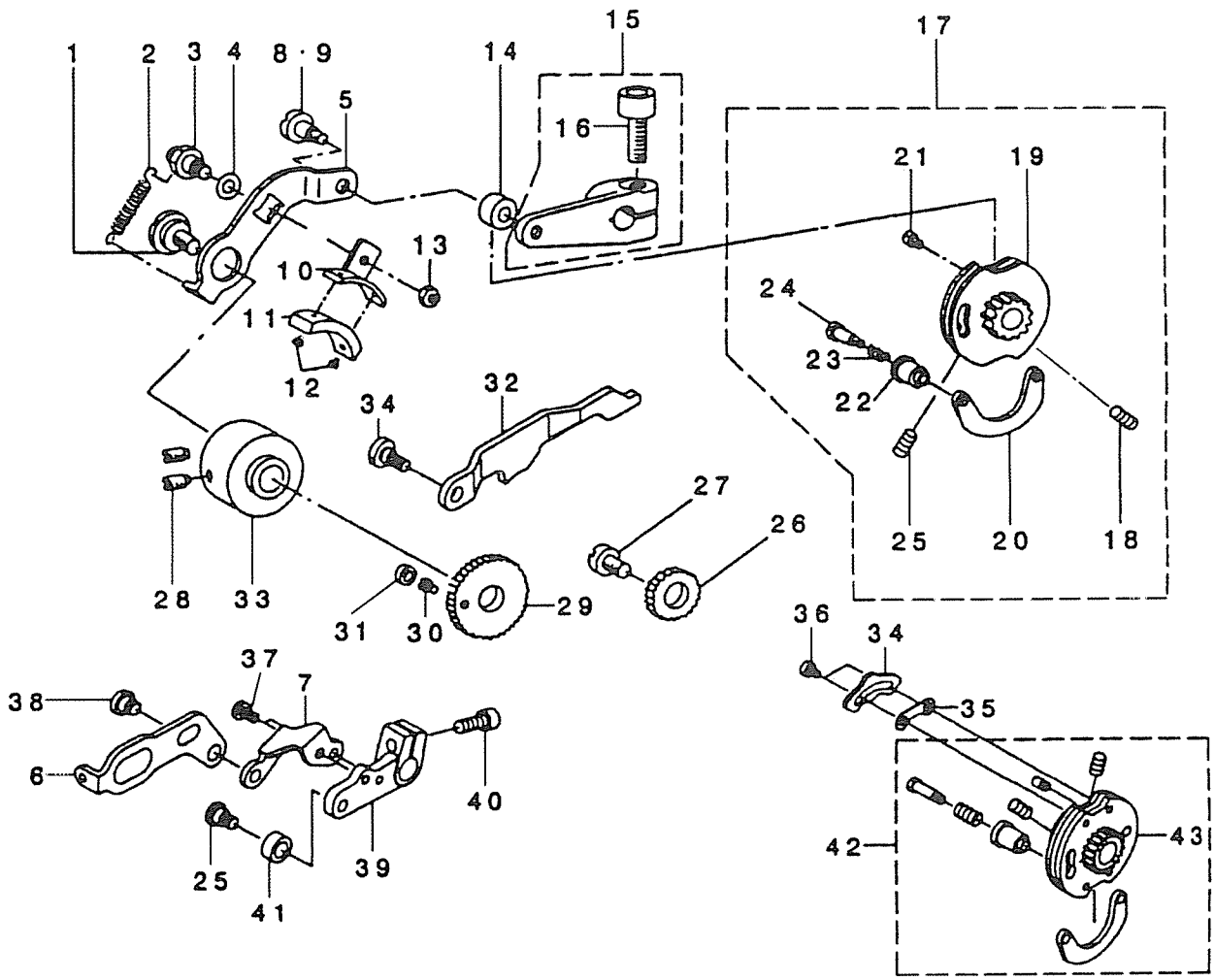


九、止动机构部件/Stop motion mechanism components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B2605-372-000	止动柱塞杆	Stop motion plunger rod	1
2		NS-6150310-SP	螺母	Nut 15/64-28	1
3		B2604-372-000	止动柱塞/冲杆	Stop motion plunger	1
4		SS-6151040-SP	螺钉	Screw 15/64-28 L=10	1
5		B2602-372-000-A	止动柱塞杆	Stop motion plunger lever	1
6		B2606-372-000	圆盘弹簧	Stop motion disc spring	30
7		B2608-280-000	橡胶垫圈	Rubber cushion	4
8		B8220-804-000	垫圈	washer 5x10.5x1	1
9		NS-6680410-SP	调节螺母	Nut 9/32-28	2
10	#01	B2601-373-N00-A	止动杆轴	Stop-motion shaft	1
11	#02	B2601-377-000	止动杆轴	Stop-motion shaft	1
12		B2603-372-000	螺钉	Screw	1
13		SS-8151570-SP	螺钉	Screw 15/64-28 L=15.0	1
14		NS-6150310-SP	螺母	Nut 15/64-28	1
15		SD-0680271-SP	合叶螺丝	Hinge screw D=6.80 H=2.7	1
16		NS-6150310-SP	螺母	Nut 15/64-28	1
17		B2615-372-000	停止螺钉	Stop screw	1
18		NS-6150310-SP	螺母	Nut 15/64-28	1
19		SM-9061003-CP	螺钉	Screw M6 L=10	1
20		B2614-372-000	止动分离杆	Stop motion trip lever	1
21		B2612-372-000	止动分离杆座	Stop motion trip lever bracket	1
22		SS-9150860-SP	螺钉	Screw 15/64-28 L=8	2
23		B2616-372-000	用于分离杆弹簧	Spring	1
24		B8133-019-000	“S”形链钩	S shaped hook	1
25		B2608-372-000	止动杆恢复弹簧销	Stop motion lever spring pin	1
26		B2609-372-000	止动杆恢复弹簧	Stop motion lever spring	1
27		B2610-372-000	螺丝栓	Screw stud	1
28		B2611-372-000	止动圆盘适用压力杆	Stop motion disc pressure lever	1

Note #01.....For -373
#02.....For -377

十、选线部件/Stitch selecting parts components

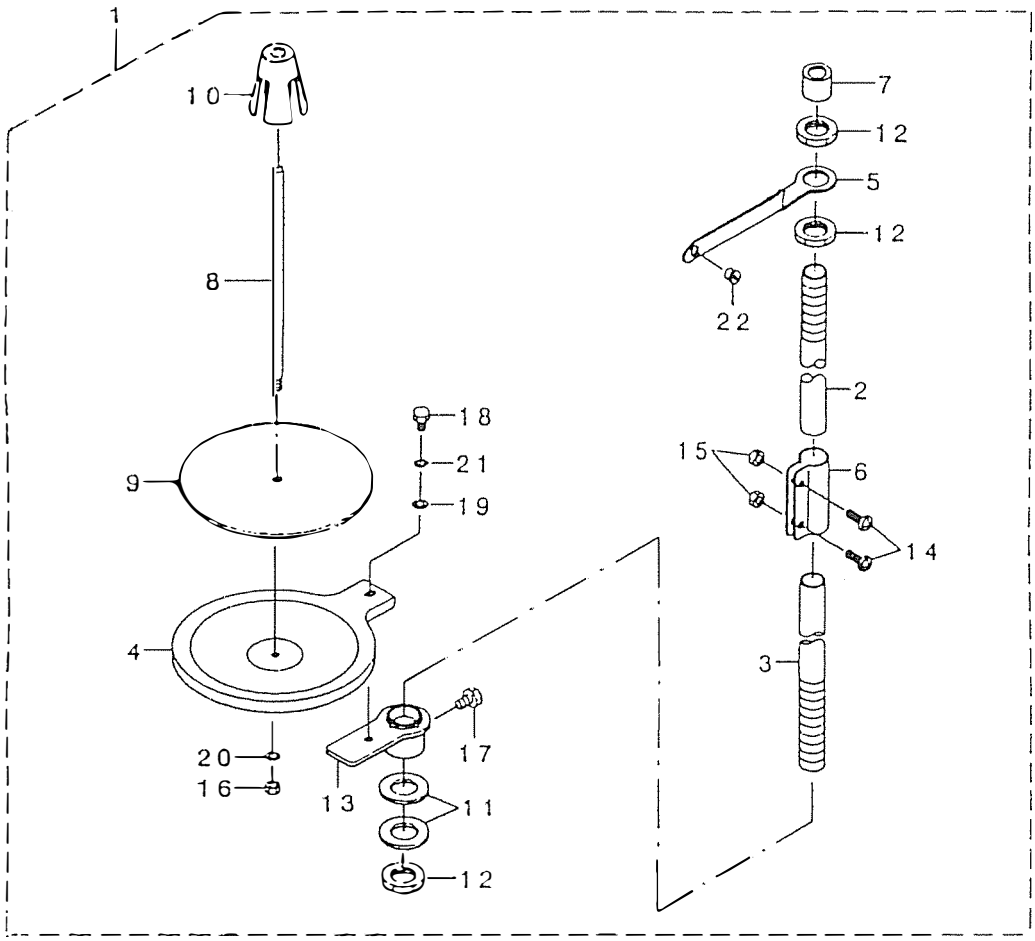


十、选线部件/Stitch selecting parts components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		SD-1127321-SP	螺钉	Hinge screw D=12.70 H=3.2	1
2		B2643-372-000	摩擦片弹簧	Spring for friction plate	1
3		B2638-372-000-A	摩擦片转动轴	Friction plate rotating shaft	1
4		WP-0850002-SP	垫圈	Washer 8.5x18x1.6	1
5	#01	B2636-372-000-A	减速杆	Speed slowing lever	1
6	#02	B2637-377-000	减速杆	Speed slowing lever	1
7	#02	B2713-377-000	调节板	Fitting plate	1
8	#01	SD-0791331-SP	螺钉	Hinge screw D=7.94 H=13.3	1
9	#02	SD-0710701-SH	螺钉	Hinge screw	1
10		B2639-372-000	摩擦片座	Friction plate holder	1
11		B2640-372-000	减速摩擦片	Speed slowing friction plate	1
12		B3211-232-000	销钉	Positioning pin	2
13		NS-6110310-SP	螺母	Nut 11/64-40	1
14	#01	B2619-372-000	止动分离杆凸缘滚辗	Stop motion tripping lever cam	1
15	#01	B2618-372-0A0-B	止动分离杆组件	Stop motion tripping lever asm	1
16		SM-6082502-TP	螺钉	Screw M8 L=25	(1)
17	#01	B2621-372-0B0	止动凸轮组件	Stop motion cam asm.	1
18		SS-8150912-TH	螺钉	Screw 15/64-28 L=9	(2)
19		B2623-372-000	止动凸轮	Stop motion cam shoe	(1)
20		B2623-372-000	止动凸轮底板	Stop motion cam shoe	(1)
21		B2624-372-000	用于止动凸轮的螺钉	Screw for stop motion cam shoe	(1)
22		B2625-372-000	止动凸轮旋钮	Stop motion cam knob	(1)
23		B2626-372-000	弹簧	Spring	(1)
24		SD-0481451-SP	螺钉	Hinge screw D=4.80 H=14.5	(1)
25	#02	SD-0790431-SP	螺钉	Hinge screw D=7.94 H=4.3	1
26		B2629-372-000	选线正齿轮（中间）	Stitch selecting spur gear, MI	1
27		B2628-372-000-A	齿轮轴	Intermediate gear shaft	1
28		SS-8151150-TP	螺钉	Screw 15/64-28 L=10.5	2
29		B2630-372-000-A	选线正齿轮	Gear, large	1
30		B2631-372-000	螺钉	Screw	1
31		B2632-372-000-A	滚圈	Roll	1
32		B2642-372-000	选线杆	Stitch adjusting lever	1
33		B2635-372-000-A	减速摩擦轮	Speed slowing friction wheel	1
34	#02	B2714-377-000	线约束槽	Thread bind notch	1
35	#02	B2719-372-000	垫片	Spacer	1
36	#02	SS-6090560-TP	螺钉	Screw 9/64-40 L=4.5	2
37	#02	SS-7110840-SP	螺钉	screw 11/64-40 L=7.8	2
38	#02	SD-0800341-SP	螺钉	Hinge screw D=8 H=3.4	1
39	#02	B2618-377-000	线迹调节臂	Stitch adjusting arm	1
40	#02	SM-6061602-TN	螺钉	Screw M6 L=16	1
41	#02	B2619-377-000	线迹调节滚圈	Stitch adjusting roller	1
42	#02	B2621-377-0B0	线迹调节凸轮组件	Stitch adjusting cam set	1
43	#02	B2621-377-0A0	线迹调节凸轮	Stitch adjusting cam asm.	(1)

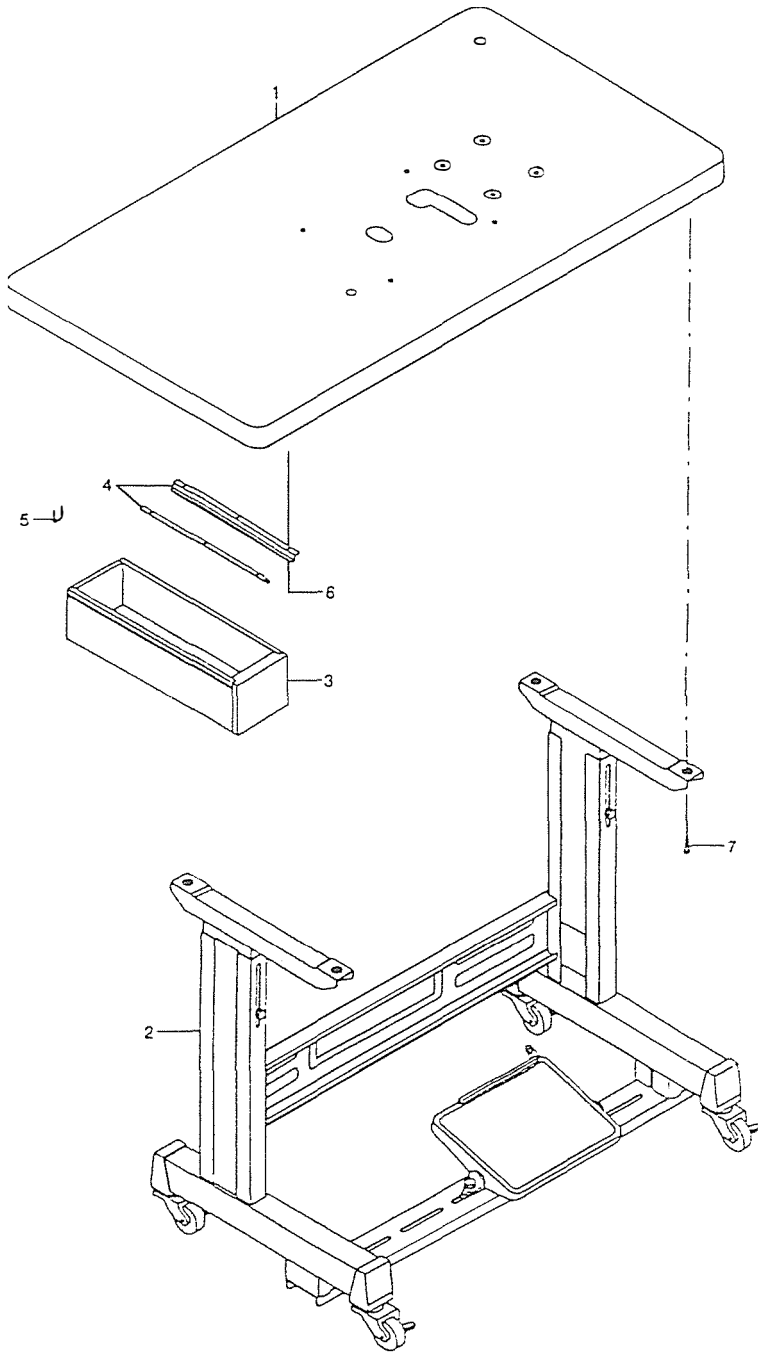
Note #01.....For -373
#02.....For -377

十二、线架部件/Thread stand components



序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		260-08359	线架组件	Thread stand asm.	1
2		229-30408	线架杆上节	Spool rest rod, upper	(1)
3		229-30309	线架杆下节	Spool rest rod, lower	(1)
4		260-08300	线架盘	Thread stand holder plate	(1)
5		260-08409	线架导线杆	Thread raising thread guide A	(1)
6		229-31307	线架杆节头	Spool rest rod joint	(1)
7		229-31406	线架杆顶防护橡皮	Spool rest rod rubber cap	(1)
8		229-31000	线盘钉	Spool pin	(1)
9		229-30903	线盘垫	Spool rest cushion	(1)
10		229-31109	线团防松垫	Spool retainer	(1)
11		WP-1702600-S0	垫圈	Washer 17x30x2.6	(2)
12		NM-6160511-SE	螺母	Nut M16x1.5	(3)
13		260-0855730408	线架支架	spool rest bracket asm.	(1)
14		SM-4051405-SE	螺钉	Screw M5 L=14	(2)
15		NM-6050001-SE	螺母	Nut M5	(2)
16		NM-6050001-SE	螺母	Nut M5	(1)
17		SM-9061080-SE	螺钉	Screw M6 L=10	(1)
18		SM-9050813-SE	螺钉	Screw M5x0.8 L=8	(1)
19		WP-0520656-SA	垫圈	Washer 5.2x9.5x0.6	(1)
20		WS-0510002-KN	弹性垫圈	Spring washer	(1)
21		WS-0521010-KN	弹性垫圈	Spring washer 5.2x8.2x1	(1)
22		229-31208	导线圈	Thread guide	(1)

十三、桌架部件/Table & stand components



序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B8201-372-A0A	电机面板	Motor table	1
2		111-59365	T形联接	T stand junction	1
3		111-55108	抽屉	Drawer	1
4		111-55207	抽屉支架	Drawer support	2
5		D8204-555-D00	抽屉挡块	Drawer stopper	1
6		SK-3311600-SE	木钉	Wood screw D=3.1 L=16	6
7		SK-383200-SE	木钉	Wood screw D=4.8 L=32	4

十四、 附件组件/Accessory parts components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		229-32800	附件包	Accessory bag	1
2		229-33105	中型螺丝启子	Screw driver, middle	1
3		229-33006	大型螺丝启子	Screw driver, large	1
4		B7119-372-000	圆形皮带	Round belt	1
5		J1067-000-000	加油器	Oiler	1
6	#01	MTQ-700B1602	机针	Needle TQx7 #16-2	1
7	#02	MTQ-100B1602	机针	Needle TQx1 #16-2	1
8		D9118-555-B00	塑料罩	Plastic cover	1
9		B1122-372-000	橡皮	Rubber	4
10		B7125-012-000	皮带钩	Belt hook	2
11		B8103-980-000	铁链	Chain	1
12		B9112-012-000	扳手	Wrench (11x14)	1
13		B9143-372-000	扳手	Wrench (7.1x8.1)	1
14	#01	B2413-373-000	量器	Gauge	1
15		260-38851	缓冲垫	Cushion asm.	1
16		B7102-372-000	电机滑轮	Motor pulley (for 50HZ)	1
17		B7103-372-000	电机滑轮	Motor pulley (for 60HZ)	1
18		MTG-4200020S	电机	Motor asm.	1
19		SS-8151150-SP	螺钉	Screw 15/64-28 L=10.5	2

Note #01.....For −373
#02.....For −377

十五、分组件/Special order spec components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B7102-372-00J	电机滑轮	Motor pulley (J)	1
2		B7101-372-00J	电机滑轮	Motor pulley (J)	1
3		B8201-372-A00-A	桌板	Table	1
4		B7102-372-00H	电机滑轮	Motor pulley	1
5		B7101-372-00H	电机滑轮	Motor pulley	1
6		B2556-372-0AA	钮钳杆钳（左）	Button clamp jaw lever asm., L	1
7		B2558-372-0AA	钮钳杆钳（右）	Button clamp jaw lever asm., R	1
8		B2556-372-CAA	钮钳杆钳（左）	Button clamp jaw lever asm., L	1
9		B2558-372-CAA	钮钳杆钳（右）	Button clamp jaw lever asm., R	1
10		D2529-373-C00-A	大钮扣送料盘/板	Feed plate, large button	1
11		MAZ-201010A0	钮钳组件	Pick-up device asm. L button	1

十六、附组件/Subclass components

序号 Ref.no	注解 Note	零件图号 Part.no	名称	Description	数量 Qty
1		B2505-373-C00-A	交叉送料凸轮	Crosswise feed cam	1
2		B2506-373-L00-A	横向送料凸轮	Lengthwise feed cam	1
3		B2505-373-C00-A	交叉送料凸轮	Crosswise feed cam	1
4		B2506-373-L00-A	横向送料凸轮	Lengthwise feed cam	1

RELIABLE

1 800 268 1649
www.reliablecorporation.com